All amounts are calculated in domestic currency.

Purchase Order Receipt Listing

Wednesday, July 26, 2017 3:52:02 PM

All Vendors PO ID PO37170 All Receipt Dates All Line Item Types All Item ID/GL/WOs All Rec. Employees All Currencies

Grouped by Vendor ID

Purchase Order ID/ Curr Type	Line Nbr/ Insp Req	Project ID	Reference/ Description/ Cert Std		O U/M / ock U/M	Required Date Required Qty	Recv Date/ Recv Emp	Recv Qty (PO U/M)	Cost Per Unit/ Recv Value	Inspected Qty/ Rejected Qty (PO U/M)	MRB Qty/ MRB Reject Qty	Book Amt
VendorID\Ven	dor Nam				ette Inc.				/			
PO37170	1	•	→M6061T6B0.3752 000	X01. f	DAS	7/27/2017	7/26/2017	20.0000	\$0.86	0.0000	0	\$17.27
CAD	No		6061T6 BAR .375 1.00 m138152	5x f	5 9-89	20.0000	PLOU01		\$17.27	0.0000	0	
	2	-	M6061T6B0.750	X02. f ≟	DAS 5	7/27/2017	7/26/2017	20.0000	\$3.73	0.0000	0	\$74.52
	No		6061-T6 Bar .750 2.00 m138152	x f	9- 89 DAS	20.0000	PLOU01		\$74.52	0.0000	0	
	3	_	M6061T6B1.000	X02. f	5	7/27/2017	7/26/2017	20.0000	\$4.73	0.0000	0	\$94.68
	No		6061-T6 Bar 1.00 2.00 m138152	x f	9-89 DAS	20.0000	PLOU01		\$94.68	0.0000	0	
	4	-	-M6061T6B1.500	X01. f	5 9-89	7/27/2017	7/26/2017	20.0000 🔨	\$5,22	0.0000	. 0	\$104.42
	No		6061-T6 Bar 1.50 1.50	x f		20.0000	PLOU01		\$104.42	0.0000	0	
		_	m138152		DAS				/		_	
	5		M6061T6B1.500	X02. f	5	7/27/2017	7/26/2017	12.0000	\$10.18	0.0000	0	\$122.21
	No		6061-T6 Bar 1.50 2.50	x f	9-89	12.0000	PLOU01		\$122.21	0.0000	0	
	_		m138152		DAS 5							
	7 No		M6061T6S.040 6061-T6 .040 She m138152	sf et sf	0.00	7/27/2017 64.0000		64.0000 L	\$3.25 \$208.06	0.0000 0.0000	0	\$208.06
	8	-	-M6061T6S.080	sf	DAG	7/27/2017	7/26/2017	64.0000 🏊	\$6.04	0.0000	0	\$386.84
	No		6061-T6 .080 She m138152		DAS	64.0000			\$386.84	0.0000	0	

Purchase Order ID/ Curr Type	Line Nbr/ Insp Req	Project ID Reference/ PO U/M / Description/ Stock U/M Cert Std	Required Date Required Qty	Recv Date/ Recv Emp	Recv Qty (PO U/M)	Cost Per Unit/ Recv Value	Inspected Qty/ Rejected Qty (PO U/M)	MRB Qty/ MRB Reject Qty	Book Amt
VendorID\Ven	dor Name	VC-CAM002 Acier Ouellette Inc.							
PO37170	9	71401-45	7/27/2017	7/26/2017	1.0000	\$0.00	0.0000	0	\$0.00
CAD	No	PROCUREMENT QUALITY CLAUSES m138152	1.0000	PLOU01		\$0.00	0.0000	0	
							Total Received C	uantity:	221.0000
						Tota	l Qty to Inspect (P	O U/M):	0.0000
							Total Reject (uantity:	0.0000
							Total Receip	ot Value:	\$1,007.99
						To	otal Balance Due Q	Quantity:	0.0000

DELIVERY - CLIENT



ACIER OUELLETTE INC.

935, Boul. du Hâvre

Salaberry de Valleyfield (Québec) J6S 5L1

Tél.: 450-377-4248 Mtl: 514-336-4248 Ext.: 800-667-4248 Fax: 450-377-5696 Mtl: 514-336-4246 Ext.: 866-456-4242 **Customer Nº**

CLI0001056

Date

2017/07/21

Delivery date

2017/07/27

Your order No

37170

Processed by

Josianne Bourdon

Salesman

Carrier

OUELLETTE VALLEYFIELD

Credit Terme

Net 30 Days

1270, ABERDEEN ST. HAWKESBURY, Ontario, K6A 1K7

DART AEROSPACE LTD

Billed to

Att: CHANTAL LAVOIE Tél.: 613-632-5200

Shipped to

, Ontario,

Instruction F-M	Delivery Route	5)	Pag	e	,	1				
Product Description /	Weight	05,	/U/M		PCS I	NB /		Inte	rnal l	Jse O	nly
Trouder Description	Weight	Qty	/ U/M	CMD	EXP	B/O	IN	I	S	С	OUT
1 FLAT ALU 3/8 X 1 6061-T6 (20) FAL-381-20 2610 1 X 20' HEAT:	9.00	20.00	PI_\$CLB		14/20	7					
2 FLAT ALU 3/4 X 2 6061-T6 (20) FAL-342-20 2591 1 X 20' HEAT:	36.36	20.00	PI_\$CLB		120	7					
3 FLAT ALU 1 X 2 6061-T6 (20) FAL-12-20 2475 1 X 20' HEAT:	48.00	20.00	FI_\$CLB		(X)	7					
4 SQUARE ALU 1 1/2 6061-T6 (20) CAL-112-20 1772 1 X 20' HEAT:	52.94	20.00	PI_\$CLB		12						

NIR: R-109516-6

DELIVERY - CLIENT

ACIER OUELLETTE INC.

935, Boul. du Hâvre

Salaberry de Valleyfield (Québec) J6S 5L1

Tél.: 450-377-4248 Mtl: 514-336-4248 Ext.: 800-667-4248 Fax: 450-377-5696 Mtl: 514-336-4246 Ext.: 866-456-4242 Date

Customer No

CLI0001056

2017/07/21

Delivery date

2017/07/27

Your order No

37170

Processed by

Josianne Bourdon

Salesman

Carrier

OUELLETTE VALLEYFIELD

Credit Terme

Net 30 Days

Att: CHANTAL LAVOIE Tél.: 613-632-5200

Shipped to

, Ontario,

Instruction F-M	Deli	very Route	5	7	Pag	е		2				
Product Description		Weight	Qty	UМ		PCS I	NB)		Inte	rnal U	se On	ly
		Weight		9/14	CMD	EXP	B/9 [/]	IN	I	S	С	OUT
5 FLAT ALU 1 1/2 X 2 1/2 6061-T6 (12) FAL-112212-12 2438		52.87	12.00	PI_\$CLB		14,0						
1 X 12' HEAT:						12,	/					
6 ALU SHEET .040 (18G) 6061-T6 (4 X 8) FEAL-040486061 3125		36.03	2.00	UN 1		2 Kv						
2 X 4' X 8' HEAT:	/											
7 ALU SHEET .081 (12G) 6061-T6 (4 X 8) FEAL-081486061 3199		73.02	2.00	UN		29 ^L						
2 X 4' X 8' HEAT:												

Billed to

DART AEROSPACE LTD

1270, ABERDEEN ST.

HAWKESBURY, Ontario, K6A 1K7

Total Weight (Lbs): 308.22

NIR: R-109516-6

All sold and delivered materials remain the property of "Acier Ouellette Inc" until payment is made in full, complete and cashed. All lost materials are at the buyer's expense. The warranty offered by "Acier Ouellette Inc." is the same as offered and honored by the manufacturer and his warranty is transferred by "Acier Ouellette Inc." to the client. The buyer hereby accepts to respect the following conditions: Net 30 days from billing date and the buyer accepts to pay administration charges of 2% per month (24% per annum) on all past due amounts over 30 days. Any default in respect with this contract will lead to payment by acceleration and permits to the seller, at his choice to claim for the balance due or the repossession of the goods sold. All claims must be made within five (5) days with this document enclosed. Any merchandise that has been damaged, cut or modified cannot be returned. All goods returned must be with our authorization and are subject to a 25% restocking charge.

Prepared By: Verified By: Delivered By: Time М D Customer's Signature Date

Total (\$CAD)

DELIVERY - USINE

Copy

CO00042358

ACIER OUELLETTE INC.

935, Boul, du Hâvre

Shipped to

, Ontario,

Salaberry de Valleyfield (Québec) J6S 5L1

Tél.: 450-377-4248 Mt: 514-336-4248 Ext.: 800-667-4248

Fax: 450-377-5696 Mtl: 514-336-4246 Ext.: 866-456-4242

Delivery date Your order No

Customer Nº

Date

2017/07/27

CLI0001056

2017/07/21

37170

Processed by

Josianne Bourdon

Salesman

Carrier

OUELLETTE VALLEYFIELD

Credit Terme

Net 30 Days

Page

1

DART AEROSPACE LTD 1270 , ABERDEEN ST.

Billed to

HAWKESBURY, Ontario, K6A 1K7

Instruction F-M **Delivery Route**

5

Att: CHANTAL LAVOIE Tél.: 613-632-5200

Ziloti dello il	TCI Y IXOUTE										
Product Description	Weight	Qty	U/M		PCS N	√B		inter	nal I	Use	Only
Product Description	weight	GrÀ	0 /141	CMD	EXP	B/O	IN	I	S	C	OUT
1 FLAT ALU 3/8 X 1 6061-T6 (20) FAL-381-20 2610 DAS	9.00	20.00	PI_\$CLB								
1 X 20' HEAT: 13121091A 9-89 2 FLAT ALU 3/4 X 2 6061-T6 (20)	36.36	20.00	PI_\$CLB								
FAL-342-20 2591 DAS 5 1 X 20' HEAT 49113 9-89											
3 FLAT ALU 1 X 2 6061-T6 (20) FAL-12-20 2475 1 X 20' HEAT: 48287 9-89	48.00	20.00	PI_\$CLB								
4 SQUARE ALU I 1/2 6061-T6 (20) DAS CAL-112-20 1772 5 1 X 20' HEAT: 68055	52.94	20.00	PI_\$CLB								

NIR: R-109516-6

_	118/15/2	
		75.39
	Sameting States of the States of States and	7

DELIVERY - USINE

Copy

CO00042358

ACIER OUELLETTE INC.

935, Boul. du Hâvre

Salaberry de Valleyfield (Québec) J6S 5L1

Tél.: 450-377-4248 Mtl: 514-336-4248 Ext.: 800-667-4248

Fax: 450-377-5696 Mtl: 514-336-4246 Ext.: 866-456-4242

Customer Nº CLI0001056

Date 2017/07/21

Delivery date 2017/07/27

37170 Your order No

Processed by Josianne Bourdon

Salesman

Carrier **OUELLETTE VALLEYFIELD**

Credit Terme Net 30 Days

Page

2

Billed to

DART AEROSPACE LTD

Instruction

1270, ABERDEEN ST. HAWKESBURY, Ontario, K6A 1K7

F-M

Delivery Route

Shipped to

, Ontario,

5

Att: CHANTAL LAVOIE Tél.: 613-632-5200

2113ct decion	Deliaci à Louce	•		_							
Product Description	Welght	Qty	U/M		PCS	NB		Inte	Internal Use Only		
1 Todace Description	Weight			CMD	EXP	B/O	IN	I	S	С	OUT
5 FLAT ALU 1 1/2 X 2 1/2 6061-T6 (12)	52.87	12.00	PI_\$CLB	11	ĺ	i l					
FAL-112212-12 2438 DAS				1				İ			
5											
1 X 12' HEAT: SXD170240) 9-89	4		-			!!!		-			
6 ALU SHEET .040 (18G) 6061-T6 (4 X 8)	36.03	2.00	ŲN								
FEAL-040486061 3125 DAS				11							
5 2 X 4' X 8' HEAT: 487125 , 9.80											
7 ALU SHEET :981 (12G) 6061-T6 (4 X 8)	73.02	2.00	ŲN	-	}						
5511 001 105051	73.02	2.00	UN	11							
ĎΨΘ											· a
2 X 4' X 8' HEAT. 358973 7358971 5								i			
9-89								1	1		
								ı	İ	İ .	
	l			11	1	i I		- 1			

Conditions:

Total Weight (Lbs): 308.22

NIR: R-109516-6

All sold and delivered materials remain the property of "Acer Quellette Inc" until payment is made in full, complete and cashed. All lost materials are at the buyer's expense. The warranty offered by "Acier Quellette Inc." is the same as offered and honored by the manufacturer and his warranty is transferred by "Acier Quellette Inc." to the client. The buyer hereby accepts to respect the following conditions: Net 30 days from billing date and the buyer accepts to pay administration charges of 2% per month (24% per annum) on all past due amounts over 30 days. Any default in respect with this contract will lead to payment by acceleration and permits to the seller, at his choice to claim for the balance due or the repossession of the goods sold. All plaims must be made within five (5) days with this document enclosed. Any merchandise that has been damaged, cut or modified cannot be returned. All goods returned must be with our authorization and are subject to a 25% restocking charge.

Prepared By :	Verified By :	Delivered By:	Time		- 1	Y	М	۵۱
						1	,	
****	1			Customer's Signature	I		Dat	e e

Total (\$CAD)

Copie d'archive

7/2

41300.

A STATE OF THE STA

Material Test Report

Manifest: 272337

Ticket: 5345729

Our Order: 400728 - 6

Cust P.O.: LAV-15648

Die: ES05691

Part: 3420604

Alloy Temper 6061 T6

<u>Si</u>

0.40

0.8

6061

Min

Max

Description; .375 x 1.000

Print Date: 1/15/14

		Ch							
<u>Fc</u>	<u>Cu</u>	Mn	Mg	<u>Cr</u>	Zn	Ti	OtherEach	OtherTotal	
	0.15		0.8	0.04					
0.7	0.40	0.15	1.2	0.35	0.25	0.15	0.05	0.15	

	•			ical Proper rength ksi	tles		
Sample ID	Cast#	_ <u>Lot #</u>	Date	<u>Ultimate</u>	Yield 2% offset	Elongation 2" gage length	
500686	13121091 <i>A</i>	DAS	1/14/14	41.76	37.37	11.4	
		9 89					

Applicable Specifications: ASTMB221213

QQA200/8

Country of Origin: ONTARIO, CANADA

Can Art Aluminum Extrusion lnc, certifies that materials shipped under this order have been inspected and tested in accordance with Aluminum Association and agreed upon customer specifications. Can Art assumes no liability for additional costs which may be incurred during the customer's manufacture and sale of its products, and is subject only to the replacement of any materials not within agreed upon specifications provided written notification is received by Can Art within 30 days from the date of shipment.

Ray Hussain - Tensile Testing

Authorized:

Evan Eng. Quality Assurance Mgr

ROCKWELL TEST

	stomer ACIERS	<i>Date</i> 8/14/20		Location Mississauga		
Customer#	61562	•		Order#	80411	
Control #	83084-1			P.O. #	337CC, 100808	
Cust Part #	2" X .750" Flat Ba			Die #	AS 7821	
Alloy & Temper	6061 T6	>		Cast #	49113	DAS
Te		ROCKM Min. Required Actual	/ELL R _E 88 95	·]		DAS 5 9-89

Si	Fe	Cu	Mn	Mg	Cr	Ni	Zn	Ti
0.4-0.8	0.7mx	0.15-0.4	0.15mx	0.8-1.2	.0435	0.05mx	0.2mx	0.20mx

Tensile testing is performed according to ASTM B557.84 requirements

Mechanical test results conform to specifications for ASTM B221/SB221

The aluminum extrusions tested meet the chemical composition requirements of the alloy specified.

Test certified by Anil Verma Date 8/14/2010

 Sapa Extrusion
 Tel: (905) - 890 - 8821

 5675 Kennedy Rd.
 Fax: (905) - 890 - 3670

 Mississauga, ON, L4Z 2H9

ある

Test de dureté Rockwell Rockwell Hardness Test

174 1)

LES ACIERS TRANSBEC (1997) LTEE.

Client / Customer :
Adresse / Address :

4054 BOUL, LE CORBUSIER, #201

LAVAL, QC H7L5R2

commande Sapa / Sapa order #:

41862

bon de commande / Purchase order #: OU-33052

de matrice / Die #: MS 15914

Description. 2"X 1" FLAT BAR

Alliage & trempage / Alloy & temper 6061 Ts

Longueur / Lenght :

Contrôle / Control #: 18682-1

Coulée / Cast # : (48287

Dureté Rockwell E /

3-89 Min. requis /

Max. permis /

Rockwell E hardness: 95 HRE

Min. required: 88 HRE

Max. permitted: 100 HRE

Composition chimique typique / Typical chemical composition:

	Si	Fe	Cu	Mn	Mg	Cr	Žn	ŤI
6063	0.20 - 0.60	0.35 Max	0.10 Max	0.10 Max	0,45 - 0.90	0.10 Max	0,10 Max	0,10 Mox
6005	0.60 - 0.90	0,35 Max	0.10 Max	0,10 Max	0,40 - 0.60	0,10 Max	0.10 Max	0.10 Max
6005A	0.66-0.74	0.14 - 0.28	0,08 - 0.16	0.18 - 0.26	0.46 - 0.54	0,03 Max	0,05 Max	0,05 Max
6061	0.40 - 0.80	0.70 Max	0.15 - 0.40	0,15 Max	0.80 - 1.20	0.04 - 0.35	0.25 Max	0.15 Max
6351	0.7 - 1.3	0,5 Max	0.10 Max	0.40 - 0.80	0.40 - 0.80		0,20 Max	0.20 Max

Nous certifions que le matériel tourni rencontre les exigences chimiques telles qu'annoncées par la norme ASTM B-221 excepté pour la section 8.2 (nombre de spécimen) et AMS QQA 200/8 excepté pour la section 4.2.3.1 (nombre de spécimen) qui sont déterminés par les exigences du client.

We hereby certify that the material supplied meets the chemical properties as published by the ASIM 8-221 except for section 8.2 (number of specimen) and AMS QQA 200/8 except for section 4.2.3.1 (number of specimen) which is determined by customer requirement.

Sincèrement vôtre,

date: 2010-05-12

Yours truly.

Bruno Morency Superviseur qualité Quality supervisor

Test de dureté Rockwell **Rockwell Hardness Test**

Client / Customer:

LES ACIERS TRANSBEC (1997) LTEE.

Adresse / Address:

4054 BOUL. LE CORBUSIER # 201

LAVAL, QC H7L5R2

commande Sapa / Sapa order #:

6110739

bon de commande / Purchase order #: OU-47005

de matrice / Die #: MS 16838

Description: &QUARE BAR 1.500"X1.50

Alliage & trempage / Alloy & temper:

6061 T6

Longueur / Lenght:

de contrôle / Control #: 80133-1

de coulée / Cast #: (

Rockwell E hardness: 95 HRE

68055

Dureté Rockwell E /

MPT. Pequis /

Min. required: 88 HRE

Max. permis /

Max. permitted: 100 HRE

Composition chimique typique / Typical chemical composition:

	SI	Fe	Cu	Mn	Mg	Cr	Zn	11
6063	0.20 - 0.60	0.35 Max	0,10 Max	0,10 Max	0.45 - 0.90	0,10 Max	0,10 Max	0,10 Max
6005	0.60 - 0.90	0,35 Max	0,10 Max	0.10 Max	0.40 - 0.60	0,10 Max_	0,10 Max	0,10 Max
6005A	0.66-0.74	0.14 - 0.28	0.08 - 0.16	0,18 - 0,26	0.46 - 0.54	0,03 Max	0.05 Max	0.05 Max
6061	0.40 - 0.80	0.70 Max	0,15 - 0,40	0.15 Max	0.80 - 1.20	0.04 - 0.35	0,25 Max	0.15 Max
4351	07-13	0.5 Max	0.10 Max	0.40 - 0.80	0.40 - 0.80		0.20 Max	0,20 Max

Nous certifions que le matériel fourni rencontre les exigences chimiques telles qu'annoncées par la norme ASTM B-22)-14 excepté pour la section 8.2 (nombre de spécimen).

We hereby certify that the material supplied meets the chemical properties as published by the ASTM B-221-14 except for section 8.2 (number of specimen).

Sincèrement votre,

date: 2016-12-15

Yours truly,

Gilles Pelletier

Technicien de la qualité

Quality technician

F.07.04 rev0 Rapport depropriétés mécaniques.doc



Global Vietnam GLOBAL VIETNAM ALUMINIUM COMPANY LIMITED

Address: MY XUAN BI-CONAC INDUSTRIAL ZONE, MY XUAN TOWN, TAN THANH DISTRICT,

BA RIA VUNG TAU PROVINCE, VIETNAM

Tel: +84(0)643924954 Fax: +84(0)643924953

MILL TEST CERTIFICATE

Date: 25 March, 2017

Consignee: SINOBEC TRADING INC.

4455 RUE COUSENS SAINT-LAURENT, QC, H4S 1X5, CANADA

PO number: P-17025 Shipping Ref No.: 17-0459 LC No.: DC HMN710996 Date of issue: 15 March, 2017

Item Code: 1906000 Die Number: D00242

Alloy & Temper 6061-T6511 Production Description FLAT BAR 1.5000" X 2.5000" X 12' 6061-T6511 D00242

Length (inch): 144

Bundle number: P-17025-009

Heat Number:SXD170240

Date: 3/6/2017

Applicable Specifications ASTM B221 STANDARDS

CHEMICAL ANALYSIS: %

Si	Mg	Fe	Cu	Mn	Cr	Zn	Ti	Λl	Other		Damanlı
31	11.18	1.0	Cu	1411	C.	241	• • • • • • • • • • • • • • • • • • • •		EACH	TOTAL	Remarks
0.623	0.928	0.206	0.267	0.016	0.101	0.011	0.021	97.732	<0.05	<0.10	3/3/2017

MECHANICAL ANALYSIS:

Ult. Strength (ksi)	Yield Strength (ksi)	Elongation % LN 2"	Remark:
40.7	35.4	10.9	3/3/2017

All profiles, each profile with each MTC, showing material shipped match aluminium alloy as per standard, with chemical analysis and mechanical analysis to match aluminium alloy standard.

We hereby certify that the item listed have been checked and tested in accordance with the specifications noted and have been found to meet all the applicable requirements. Certifications are kept on file for 36 months from the date of purchase and are available for review upon request, referring to ASTM and the PO number.

Quality Manager



TRUNG TÂM KIỂM NGHIỆM CÔNG TY TNHH NHÔM TOÀN CẦU VIỆT NAM GLOBAL VIETNAM ALUMINIUM CO., LTD TESTING CENTER R 211559

Arconic DAVENPORT WORKS 4879 State Street Bettendorf, IA 52722 CERTIFIED INSPECTION REPORT Ship From: RIVERDALE. IA. We hereby cardly that the material covered by this confidence has been impected with, and has been tound to meet the applicable requirements described therest, including any operatesions torning a part of the description and that samples representative of the material met the composition brids and had the mechanical properties shown on the book of this sheet. 3143792 Ship Date Invoice No. Arconic No. 1000894587-2 DPE-94587-2 11222555 Item 00000 This test report shell not be reproduced except in full, without the wolten approved of the Quality Department. No elemetion, addition or corer change is authorized to be made to this certificate. The recording of table, fictificate, or otherwise insufficate by any recipient may be purchased as a fellory worder applicately early recipient may be purchased as a fellory worder applicately early. 2017-02-23 Customer Arconic Item P.O. No / Govt Contract No. Rod Woodell Rob Woods Director of Manufacturing Developert Works Quality Assurance Manager Page 1 of 2 From Description 0.04 IN TK (+0.0000 -.0035) X 48.0 IN H (+.125 -.125) X 144.0 IN IN (+.15625 -.15625) CAT D 126862 (N) A/T 6061--TE PLAT SHEET POR DISTRIBUTORS TOLERANCE GUARANTEED. AMS4027 REV N ANSIH35.2 REV 2013 EXC_MRK ASME-S8-209 REV 15 EXC MRK (ASTNB209 LEV 14 ((MARKED)) KRAFT PAPER INTERLEAVED HAX GROSS SKID NGT: 4750 LB QUAN TOL +/-25 t COR D126862 REV 43 CUST REQ 17-03-25 *** W/E 17-04-01 *** Quantity HOH Inspector Clock Numbers Weight Num Package Ticket PC 27279 47435 27887 299257 · 487125 € 2926 118 Notes for CQR: D126862.43 PRODUCT PRODUCED TO THE REQUIREMENTS OF AMS4027 REV N ALSO MEET THE REQUIREMENTS OF AMS-QQ-A-250_11 ORIGINAL REVISIO N DATED 1997-08-01.

UTS TYS EL4D Impr Dir KSI KSI PCT Max T6 Long Transv.

5

9-89

Dir

Min 42.0

FE CU MN NG CR ZN TI Each Total Aluminum Chemical Composition DAS Max 0.8 0.7 0.40 0.15 1.2 0.35 0.25 0.15 0.05 0.15 Alloy 6061 Min 0.40 0.15 0.8 0.04 - Mechanical, Physical, Metallography, Quantometer Results -----

10

CQR: D126862.43 -Specification Limits ------

No-> UTS TYS EL4D Test KSI KSI PCT Long Transv. 10 48.6 40.9 12.4

35.0

CERTIFIED INSPECTION REPO	RT		Arconic	DAVENPOR	RT WORKS 4879	State Street Bettendo	•
Via hereby certly that the metadal covered by this certical applicable requirements described themin, including any a representative of the metadal met the composition limits as	pecifications forming a past of t	he description and that s	emples 3143792	B.L. No.	Invoice No.	Ship From: Arconic No.	RIVERDALE, IA.
The best report shall not be reproduced except in full, with addition or other whange is authorized to be made to this or adarenees or extress on this confection by any recipient or Per.	entificate. The recording of lets	e, fictious , or otherwise	teration, 2017-02-23 fraudulent	11222555 liem 1 Contract No.	00000 Customer	1000894587-2 Arconic Item	DPE-94587-2
Red Woodell Red Woodel Develop of Manufacturing Developed Works		Terrence Thorn pray Assurance Manager					-
			Page 2 of 2				
Lot: 487125 - Machanical,	Physical, Meral 48.8 48.7 48.6 48.8 49 49 49.1 49.1	41.1 41.1 40.9 41.1 41.3 41.3 41.2 41.3	ntometer Results (d 12.4 12.6 12.5 12.7 12.3 12.6 12.7 12.3 12.6	cont.)	<u>-</u>	······································	

This material was malted in the United States or a Qualifying Country [REF DFARS 225.872.1(a)]; it was manufactured in the United States

Chemical - OES SI FE CU NN MG CR ZN TI Other Each Other Total Actuals 0.61 0.4 0.24 0.14 0.9 0.16 0.00 0.03 < 0.05 < 0.15

Cast Number T114421

CERTIFIED INSPECTION REPORT

Arconic

DAVENPORT WORKS 4879 State Street Bettendorf, IA 52722

We havely carrily that the enturied covered by the carriecte has been respected with, and has been found to meet the applicable requirements described thereby, including any specifications forming a part of the description and that samples impresentative of the entered must he composition have and had the inscriptions properties shown on the base of the sheet.

This lost report shall not be reproduced except in full, without the written approved at the Quality Department. No attendion, addition of other change is authorized to be mude to this certificate. The recording of false, fictious, or otherwise translated statements or entries on this certificate by any nuclptient may be purethed as a fatory under applicable lew.

Per:

S. North-Nendu Bonnesen Terrence Thom Manufacturing Oirector - Covengort & Saletter

Ship From: RIVERDALE, IA. 3194831 B.L. No. Invoice No. Arconic No. Item Ship Date 2017-04-25 11293075 00000 1000915319-1 DPR-15319-1 Arconic Item P.O. No / Govt Contract No. Customer

Page 1 of 3

T6 FLAT SHEET FOR DISTRIBUTORS TOLERANCE GUARANTEED. AMS1027 REV N. AMSIH35.2 REV 2013 EXC_MRK ASME-SB-209 REV 15 EXC_MRK ASTME209 REV 14 ((MARKED)) KRAFT PAPER INTERLEAVED MAX GROSS SKID WGT: 4750 LB QUAN TOL +/-10 % CQR D126901 REV 46 CUST REQ 17-04-19 *** W/E 17-04-22 ***

Num	Package Ticket	Lot	Walght	Quantity	UON	Inspector Clock Numbers
_		11787877				
1	275874	~ 358972 []////(A)	3849	75	PC	27709 47476
2	277855 DAS	1350022 0/23/40	1896	37	PC	27709 47476
3	277855	7358973 7727/39	1794	35	PC	27709 47476
	3 (
	9-89		7539	147		

Quelly Assurance Manager

Notes for CQR: D126901.46 PRODUCT PRODUCED TO THE REQUIREMENTS OF AMS4027 REV N ALSO MEET THE REQUIREMENTS OF AMS-QQ-A-250_11 ORIGINAL REVISIO N DATED 1997-08-01.

CQR: D126901.46 -Specification Limits -----

PYT BLAD Tupr Dir KSI KSI PCT Long Transv. Min 42.0 35.0

Other Other Chemical Composition SI FE CU NN MG CR 2N TI Each Total Aluminum 0.8 0.7 0.40 0.15 1.2 0.35 0.25 0.15 0.05 0.15 Max Min 0.40 0.15 0.8 0.04 REMAIN

CERTIFIED INSPECTION REPORT

Arconic

DAVENPORT WORKS 4879 State Street Bettendorf, IA 52722

We harely carrily that the majoral covered by the carrifosis has been inspected with, and has been found to meet the applicable requestments described theren, including any specifications forming a part of the describion and that samples representative of the instensional properties shown on the face of this spect.

This test report shall not be reproduced escapt in full, without the written approval of the Custility Department. No absencion, addition or other change is authorized to be made to this certificate. The recording of false, Scittious, or otherwise frauduced statements or writes in this certificate by may recipient may be purished as a fetting under applicable law.

Per

S. Name

Nanus Brinsesen

Manufacturing Director - Daysopoid & Satelfase

Quality Assurance Manager

Quality Assurance Manager

			Ship From:	RIVERDALE, IA.
3194831 Ship Date	o B.L. No.	Invoice No.	Arconic No.	Item
2017-04-25	11293075	00000	1000915319-1	DPE-15319-1
P.O. No/Govi	Contract No.	Customer	Arconic I	ten

Page 2 of 3

CQR:	D126901.	46 -Specific	cation	a Limit	B (CC	nt.) -										 		
Lot:	358972	- Mechani	Lcal,	Physic	al, M	etallo	graphy	, Qu	antonet	er Re:	sults					 	 	
			No->		UTS		TYS		EL4D									
Tmpr	Dir		Topt	:	KS1	:	KSI		PCT									
T6	Long	Transv.	10		50.	2	43.9		12.5									
					50.	1	43.8		12.7									
					50.	1	43.9		12.2									
					50.	1	43.9		12.1									
					50.	1	43.8		12.4									
					50.	2	44.2		12									
					50.	3	43.8		12									
					50.	2	43.7		12.1									
					50.	5	43.9		12.3									
					50.	3	43.8		12.2									
	10b																	
	Number	Chemical -	- ORS		PE	CU	WN	MG	CR	ZN	TI			Other	Total			
H2743		Actuals		0.65	0.5	0.22	0.06	0.9	0.16	0.02	0.02	< 0.05		< 0.15				
DOC!	358973	- Mechani	cai,	Physic	:al, M	etullo	graphy	, ' бл	entomet	er Res	ults					 	 	
~~~	n!		No-2		UTS		TYS		ELAD									
Tepr TG	Dir	<b>—</b>	Test		KSI		KSI		PCT									
10	rong	Transv.	10		50.		44.2		12.2									
					50.		44		12.2									
					50.		44.2		11.7									
					50.		44.2		11.8									
					50.		44.1		11.9									
					50.		44.3		11.6									
					50.		44.3		11.5									
					50.		44.2		11.7									
					50.		43.8		12.1									
					50.		43.8		12.1									
	Number	Chemical -	ORS	SI	FE	CU	MIN	MG	CR	ZN	TI	Other	Each	Other	Total			
H2743	U25	Actuals		0.65	0.5	0.24	0.06	0.9	0.16	0.03	0.02	< 0.05		< 0.15				

*CERTIFIED INSPECTION REPORT	Arc	conic	DAVENPO	RT WORKS 4879	State Street Bettende	orf, IA 52722
We havely carely that the material covered by this carelicate has been inspected with, and has been found in applicable requirements described therein, including any specifications foreign a part of the description and representative of the meterial mat the compositors imits and had the mechanical properties shown on the far	Date a service	3194831 Ship Date	B.L. No.	Invoice No.	Ship From: Arconic No. Item	RIVERDALE, IA.
This test report shall not be in produced except in it.d., without the written approval of the Custry Department, addition or other change is authorized to be made to that cardicate. The recording of take, fastious, or other statements or entries on this cartificate by any recipient may be punished as a fatiny under applicable lieu. Play.	, No atergron, Inviso Taudulant	2017-04-25 P.O. No./Govt	11293075 Contract No.	00000 Customer	1000915319-1 Arconic Item	DPE-15319-1
Nandu Sinhesen Terrenport & Selentare Outsite Outsite Assurance Me						

Page 3 of 3

This material was melted in the United States or a Qualifying Country [REF DFARS 225.872.1(a)]; it was manufactured in the United States

# CERTIFIED INSPECTION REPORT

# Arconic

3128552

Ship Date

2017-02-04

P.O. No./Govt Contract No.

C73854 Ln#: 1

# DAVENPORT WORKS 4879 State Street Bettendorf, IA 52722

Invoice No.

00000

Customer

Ship From:

1000887223-1

Arconic Item

Arconic No.

RIVERDALE, IA.

DP-87223-1

We havely stall the measured covered by this cartificate has been improved with, and has been thurst to meet the applicable requirements described thanks, arounding any specifications farming a put of the describion and that samples representative of the measured and the composition are and had the reachested properties between at the lace of the sheet.

This lest report shad not be reproduced excluting tall, without ins written approved of the Charty Department, the starment, addition or effect energy is authorized to be medd to this continues. The recording of inter, definition, or otherwise insultant attributes or only on the continues of the continues of the continues of the continues of the continues of the continues of the continues of the continues of the continues of the continues of the continues of the continues of the continues of the continues of the continues of the continues of the continues of the continues of the continues of the continues of the continues of the continues of the continues of the continues of the continues of the continues of the continues of the continues of the continues of the continues of the continues of the continues of the continues of the continues of the continues of the continues of the continues of the continues of the continues of the continues of the continues of the continues of the continues of the continues of the continues of the continues of the continues of the continues of the continues of the continues of the continues of the continues of the continues of the continues of the continues of the continues of the continues of the continues of the continues of the continues of the continues of the continues of the continues of the continues of the continues of the continues of the continues of the continues of the continues of the continues of the continues of the continues of the continues of the continues of the continues of the continues of the continues of the continues of the continues of the continues of the continues of the continues of the continues of the continues of the continues of the continues of the continues of the continues of the continues of the continues of the continues of the continues of the continues of the continues of the continues of the continues of the continues of the continues of the continues of the continues of the continues of the continues of the continues of the continues of th

Red World

Director of Manufacturing Deversors Works

Quelty Attention Manage

Page 1 of 2

Item Description 0.08-IN TK (+0.0000 -.0045) X 48.0 IN W (+.125 -.125) X 144.0'IN LN (+.15625 -.15625) CAT D 126901 (N) A/T 6061-T6 FLAT SHEET FOR DISTRIBUTORS TOLERANCE GUARANTEED. AMS4027 REV N ANSIHJ5.2 REV 2013 EXC MRK ASME-SB-209 REV 15 EXC MRK ASTMB209 REV 14 ((MARKED)) KRAPT PAPER INTERLEAVED MAX GROSS SKID MGT: 4750 LB QUAN TOL +/10 t CQR D126901 REV 46 CUST REQ 17-01-30 *** W/E 17-03-11 ***

11202325 Item

Nua Package Ticket Lot Height Quantity UOX Inspector Clock Numbers 1 274797 358971 / 3855 75 PC : 27843 47275

Notes for COR: D126901.46 PRODUCT PRODUCED TO THE REQUIREMENTS OF AMS4027 REV N ALSO MEET THE REQUIREMENTS OF AMS-QQ-A-250_11 DRIGINAL REVISIO N DATED

CQR: D126901.46 -Specification Limits ----

UTS TYS ZL4D Tupe Dir KSI KSI PCT T6 Long Transv. Xax Min 42.0 35.0

Chemical Composition Other Other SI FE CU MN MG CR ZN TI Bach Total Aluminum 0.8 0.7 0.40 0.15 1.2 0.35 0.25 0.15 0.05 0.15 Alloy 6061 Min 0.40 0.15 0.8 0.04 Lot: 358971 - Mechanical, Physical, Metallography, Quantometer Results

Tmpr Dir Test KSI XSI T6 PCT Long Transv. 10 49.8 43.2 12.5

DAVENPORT WORKS 4879 State Street Bettendorf, IA 52722

# Arconic

# on's soom at insure most and true. Elses betraqued most and standards will yet benevats bitteam on's but yetters yettered delt solgenes true been redeptused on't to long a gradual armittationary apen graduates, personal benevates personates produced plans and the sold long absolutes and to existence only long absolutes and to existence only long absolutes and to existence only long absolutes and to existence only long absolutes and to existence only long absolutes and to existence only long absolutes and to existence only long absolutes and to existence only long absolute and the existence of the absolute and the existence of the absolute and the absolute and the absolute and the absolute and the absolute and the absolute and the absolute and the absolute and the absolute and the absolute and the absolute and the absolute and the absolute and the absolute and the absolute and the absolute and the absolute and the absolute and the absolute and the absolute and the absolute and the absolute and the absolute and the absolute and the absolute and the absolute and the absolute and the absolute and the absolute and the absolute and the absolute and the absolute and the absolute and the absolute and the absolute and the absolute and the absolute and the absolute and the absolute and the absolute and the absolute and the absolute and the absolute and the absolute and the absolute and the absolute and the absolute and the absolute and the absolute and the absolute and the absolute and the absolute and the absolute and the absolute and the absolute and the absolute and the absolute and the absolute and the absolute and the absolute and the absolute and the absolute and the absolute and the absolute and the absolute and the absolute and the absolute and the absolute and the absolute and the absolute and the absolute and the absolute and the absolute and the absolute and the absolute and the absolute and the absolute and the absolute and the absolute and the absolute and the absolute and the absolute and the absolute and t ТЯОЧЭЯ ИОІТОЭЧЕЙ ОЗІЧГЯЯ

T46858 :307

CARRY LAN: 1 P.O. No / Govi Contract No. dadi pionnyk Customer 11202322 DE-81553-T T000581537-T 00000 5071-03-04 Arconic No. 2010 Date Involce No. B.L. No. RIVERDALE, IA. Ship From:

Page 2 of 2 Rock of West Crame Congress West.

notimate out in programme () and the seption of the section of the section of the black of the section of the section of the section of the section of the section of the section of the section of the section of the section of the section of the section of the section of the section of the section of the section of the section of the section of the section of the section of the section of the section of the section of the section of the section of the section of the section of the section of the section of the section of the section of the section of the section of the section of the section of the section of the section of the section of the section of the section of the section of the section of the section of the section of the section of the section of the section of the section of the section of the section of the section of the section of the section of the section of the section of the section of the section of the section of the section of the section of the section of the section of the section of the section of the section of the section of the section of the section of the section of the section of the section of the section of the section of the section of the section of the section of the section of the section of the section of the section of the section of the section of the section of the section of the section of the section of the section of the section of the section of the section of the section of the section of the section of the section of the section of the section of the section of the section of the section of the section of the section of the section of the section of the section of the section of the section of the section of the section of the section of the section of the section of the section of the section of the section of the section of the section of the section of the section of the section of the section of the section of the section of the section of the section of the section of the section of the section of the section of the section of the section of the section of the s

SI EE CU NOM NG CE ZN II OCHEFI 0.65 0.5 0.22 0.06 0.9 0.16 0.02 0.02 < 0.05 Ocher Each Other Total SEDEFARH MM Chemical - OES SI CABE Number 13.9 EÞ 8.64 13.2 2.61. P.EI 43.2 6.61 9.21 1.64 4.63 13'1 **E**} 8.61 13.4 4.54 8.61 . 3'27 6.53 2.02 - Mochanical, Physical, Katallograpy, Quancometer Results (cont.) 13'8 E. E> 6.65

cates besting on a United States or a Qualitying Country (REF DFASS 225.812.1(a)); it was manufactured in the United States



Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 Tel: 613 632 9577

Fax: 613 632 1053

### **PURCHASE ORDER**

### Purchase Order ID PO37170

Purchase Order Date 7/21/2017 PO Print Date 7/21/2017

Page Number 1 of 4

Order From:

ACIER OUELLETTE INC. 935 BOUL. DU HAVRE VALLEYFIELD, QC J6S 5L1 CA VC-CAM002

Ship To: DART AEROSPACE LTD

1270 ABERDEEN

HAWKESBURY, ON K6A 1K7

CANADA

PMAILED

JUL 2 0 2017

**Contact Name** 

Vendor Phone

**Ship To Contact** 

Ship To Phone

800 667 4248

Yours ppd

Buyer

Chantal Lavoie

1/4248

Customer POID
Customer Tax #

10127-2607

Terms

Net 30 CAD

Currency FOB

FCA - (Free Carrier)

Ship Via: Ship Acct:

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	M6061T6B0.375X01.000	6061T6 BAR .375 x 1.00	7/27/2017 Yes		20.00 f	\$1.12	\$22.41
	AS PER QQ-A-225/8 OR AN	0/T6511/T62 ALUMINUM BAR //S-QQ-A-225/8 OR AMS 4117/4128  Q-A-200/8 OR AMS 4160 OR ASTI			14		

2 M6061T6B0.750X02.000

ASTM B221

6061-T6 Bar .750 x 2.00

7/27/2017

Yes

7/27/2017

MATERIAL: 6061-T6/T6510/T6511/T62 ALUMINUM BAR AS PER QQ-A-225/8 OR AMS-QQ-A-225/8 OR AMS 4117/4128/4115/4116 OR QQ-A-200/8 OR AMS-QQ-A-200/8 OR AMS 4160 OR ASTM B211 OR ASTM B221

Line Total:

\$22.41

\$4.84

\$96.70

1x

Line Total:

\$96.70

PO Instructions: QUOTATION SOU0047090

Note:



ACIER OUELLETTE INC.

VALLEYFIELD, QC J6S 5L1

935 BOUL. DU HAVRE

Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7

Tel: 613 632 9577 Fax: 613 632 1053

### **PURCHASE ORDER**

### Purchase Order ID PO37170

Purchase Order Date 7/21/2017 PO Print Date 7/21/2017

Page Number 2 of 4

Order From:

CA

VC-CAM002

DART AEROSPACE LTD Ship To:

1270 ABERDEEN

HAWKESBURY, ON K6A 1K7

**CANADA** 

**Contact Name** 

Vendor Phone

800 667 4248

**Ship To Contact** 

Ship To Phone Ship Via:

Yours ppd

Ship Acct:

M6061T6B1.000X02.000

6061-T6 Bar 1.00 x 2.00

7/27/2017

Yes

7/27/2017

MATERIAL: 6061-T6/T6510/T6511/T62 ALUMINUM BAR AS PER QQ-A-225/8 OR AMS-QQ-A-225/8 OR AMS 4117/4128/4115/4116 OR QQ-A-200/8 OR AMS-QQ-A-200/8 OR AMS 4160 OR ASTM B211 OR ASTM B221

Buyer Chantal Lavoie

**Customer POID** 

Customer Tax# 10127-2607 Net 30 Terms CAD Currency

**FOB** 

FCA - (Free Carrier)

20.00

12.00

\$6.14

\$122.86

Line Total: \$122.86 M6061T6B1.500X01.500 ℃ 6061-T6 Bar 1.50 x 1.50 7/27/2017 20.00 \$6.78 \$135.50 f Yes

7/27/2017

MATERIAL: 6061-T6/T6510/T6511/T62 ALUMINUM BAR AS PER QQ-A-225/8 OR AMS-QQ-A-225/8 OR AMS 4117/4128/4115/4116 OR QQ-A-200/8 OR AMS-QQ-A-200/8 OR AMS 4160 OR ASTM B211 OR ASTM B221

M6061T6B1.500X02.500 6061-T6 Bar 1.50 x 2.50

7/27/2017

7/27/2017

Yes

MATERIAL: 6061-T6/T6510/T6511/T62 ALUMINUM BAR AS PER QQ-A-225/8 OR AMS-QQ-A-225/8 OR AMS 4117/4128/4115/4116 OR QQ-A-200/8 OR AMS-QQ-A-200/8 OR AMS 4160 OR ASTM B211 OR

Line Total:

\$135.50

\$13.22 \$158.59

ASTM B221

PO Instructions: QUOTATION SOU0047090

Note:



Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 Tel: 613 632 9577

Fax: 613 632 1053

## **PURCHASE ORDER**

### Purchase Order ID PO37170

Purchase Order Date 7/21/2017 PO Print Date 7/21/2017

Page Number 3 of 4

Order From:

ACIER OUELLETTE INC. 935 BOUL. DU HAVRE VALLEYFIELD, QC J6S 5L1 CA

VC-CAM002

DART AEROSPACE LTD Ship To:

1270 ABERDEEN

HAWKESBURY, ON K6A 1K7

**CANADA** 

**Contact Name** 

Vendor Phone

800 667 4248

**Ship To Contact** Ship To Phone

Ship Via: Ship Acct:

Yours ppd

Buyer

Chantal Lavoie

**Customer POID** 

Customer Tax#

10127-2607 Net 30 CAD

Terms Currency

**FOB** 

FCA - (Free Carrier)

Line Total:

\$158.59

M6061T6R1.000

ROUND BAR 1.00"

7/27/2017

Yes

20.00

\$2.47

\$49.39

7/27/2017

MATERIAL: 6061-T6/T6510/T6511/T62 ALUMINUM ROUND BAR AS PER QQ-A-225/8 OR AMS-QQ-A-225/8 OR AMS 4117/4128/4115/4116 OR QQ-A-200/8 OR AMS-QQ-A-200/8 OR AMS 4160 OR ASTM B211 OR ASTM B221

M6061T6S.040

6061-T6 .040 Sheet

7/27/2017

7/27/2017

Yes

64.00

Line Total:

\$4.22

\$270.00

\$270.00

\$49.39

MATERIAL: 6061-T6/T62 ALUMINUM SHEET AS PER QQ-A-250/11 OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209

PO Instructions: QUOTATION SOU0047090

Note:



Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 Tel: 613 632 9577

Fax: 613 632 1053

### **PURCHASE ORDER**

### Purchase Order ID PO37170

Purchase Order Date 7/21/2017 PO Print Date 7/21/2017

Page Number 4 of 4

Order From:

ACIER OUELLETTE INC. 935 BOUL. DU HAVRE VALLEYFIELD, QC J6S 5L1 CA

VC-CAM002

Ship To: DART AEROSPACE LTD

1270 ABERDEEN

HAWKESBURY, ON K6A 1K7

**CANADA** 

Contact Name

Vendor Phone

800 667 4248

**Ship To Contact** Ship To Phone

Ship Via:

Ship Acct:

M6061T6S.080

Yours ppd

6061-T6 .080 Sheet

7/27/2017

7/27/2017 Yes Chantal Lavoie

**Customer POID** 

Customer Tax# 10127-2607 Net 30 **Terms** Currency CAD

**FOB** 

Buyer

FCA - (Free Carrier)

64.00

\$7.84

\$502.00

MATERIAL: 6061-T6/T62 ALUMINUM SHEET AS PER OO-A-250/11 OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209

71401-45

**PROCUREMENT QUALITY CLAUSES** 

7/27/2017

No

7/27/2017

Procurement Quality Clauses

A005 right of entry

A012 chemical and physical test report A016 personnel qualification

A017 raw material identification (as applicable) A026 certification of material conformance

A041 quality management system

A042 dart notification by supplier

A043 retention of quality document

Line Total:

\$502.00

\$0.00

\$0.00

Line Total:

\$0.00

PO Total:

\$1,357.45

PO Instructions: QUOTATION SOU0047090

Note: Terms & Condition of Purchasing (Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Change Nbr:

1

Change Date:

7/21/2017



### **ACIER OUELLETTE INC.**

935, Boul. du Hâvre

Salaberry de Valleyfield (Québec) J6S 5L1

Tél.: 450-377-4248 Mtl: 514-336-4248 Ext.: 800-667-4248 Fax: 450-377-5696 Mtl: 514-336-4246 Ext.: 866-456-4242

# Quotation

SOU0047090

Billed to

DART AEROSPACE LTD

1270, ABERDEEN ST. HAWKESBURY, Ontario, K6A 1K7

Shipped to

, Ontario,

Att: CHANTAL LAVOIE Tél.: 613-632-5200

Customer N°

CLI0001056

Date

2017/07/20

**Revision Nº** 

0

**Prices valid until** 

2017/07/27

Your Order No

Processed by

Josianne Bourdon

Salesman

**JOSIANNE** 

Carrier

**OUELLE SDV** 

**Credit Terms** 

Net 30 Days

Page

1

Product N° and description	Weight	Qty	U/M	Qty	U/M	Price	Pcs Nb	Price	Amoun
SHEET SS 16G SS304-2B (4 X 8) FESS-16G489042B <b>3419</b> 3 X 4' X 8' STOCK	252.00	96.00	PI2_\$CLB	3.00	UN		3.00	208.276	624.83
SHEET SS 20G SS304-2B (4 X 8) FESS-20G483642B <b>3430</b> 3 X 4' X 8' STOCK	150.72	96.00	PI2_\$CLB	3.00	UN		3.00	125.073	375.22
FLAT ALU 3/8 X 1 6061-T6 (20) FAL-381-20 <b>2610</b> 1 X 20' STOCK	9.00	20.00	PI_\$CLB	1.00	UN		1.00	22.410	22.41
FLAT ALU 1/2 X 5 6061-T6 (20) FAL-125-20 <b>2491</b> 1 X 20' STOCK	58.82	20.00	PI_\$CLB	1.00	UN		1.00	132.900	132.90
FLAT ALU 3/4 X 2 6061-T6 (20) >, FAL-342-20 <b>2591</b> 1 X 20' STOCK	36.36	20.00	PI_\$CLB	1.00	UN		1.00	96.700	96.70
FLAT ALU 1 X 2 6061-T6 (20) FAL-12-20 . 2475 1 X 20' STOCK	48.00	20.00	PI_\$CLB	1.00	UN		1.00	122.860	122.86
SQUARE ALU 1 1/2 6061-T6 (20) CAL-112-20 <b>1772</b> 1 X 20' STOCK	52.94	20.00	PI_\$CLB	1.00	UN		1.00	135.500	135.50
FLAT ALU 1 1/2 X 2 1/2 6061-T6 (12) FAL-112212-12 <b>2438</b> 1 X 12' 2-3 DAYS	52.87	12.00	PI_\$CLB	1.00	UN		1.00	158.590	158.59
CARRE AL. 4 1/2 N 1 X 48" 2-3 DAYS	0.00	1.00	UN	1.00	UN		1.00	350.000	350.00
ROUND ALU 9/16 6061-T6 (12) RAL-916-12 5178 2 X 12' STOCK	7.03	2.00	UN	2.00	UN		2.00	55.000	110.00



#### **ACIER OUELLETTE INC.**

935, Boul. du Hâvre

Salaberry de Valleyfield (Québec) J6S 5L1

Tél.: 450-377-4248 Mtl: 514-336-4248 Ext.: 800-667-4248 Fax: 450-377-5696 Mtl: 514-336-4246 Ext.: 866-456-4242

# Quotation

SOU0047090

Billed to

DART AEROSPACE LTD

1270, ABERDEEN ST. HAWKESBURY, Ontario, K6A 1K7

Shipped to

, Ontario,

Att: CHANTAL LAVOIE Tél.: 613-632-5200

Customer N°

CL10001056

Date

2017/07/20

**Revision Nº** 

0

**Prices valid until** 

2017/07/27

Your Order No

Processed by

Josianne Bourdon

Salesman

JOSIANNE

Carrier

**OUELLE SDV** 

**Credit Terms** 

Net 30 Days

Page

2

Weight	Qty	U/M	Qty	U/M	Price	Pcs Nb	Price	Amoun
18.50	20.00	PI_\$CLB	1.00	UN	Walter State of the Control	1.00	49.390	49.39
							To be an Australia control	The second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of the second of th
36.03	2.00	UN	2.00	UN		2.00	135.000	270.00
73.02	2.00	UN	2.00	UN		2.00	251.000	502.00
0.00	2.00	UN	2.00	UN		2.00	165.000	330.00
		\$						3.95
		į						
1 1								
	18.50 36.03 73.02	18.50 20.00 36.03 2.00 73.02 2.00	18.50 20.00 PI_\$CLB  36.03 2.00 UN  73.02 2.00 UN  0.00 2.00 UN	18.50 20.00 PI_\$CLB 1.00  36.03 2.00 UN 2.00  73.02 2.00 UN 2.00  0.00 2.00 UN 2.00	18.50 20.00 PI_\$CLB 1.00 UN  36.03 2.00 UN 2.00 UN  73.02 2.00 UN 2.00 UN  0.00 2.00 UN 2.00 UN	18.50 20.00 PI_\$CLB 1.00 UN  36.03 2.00 UN 2.00 UN  73.02 2.00 UN 2.00 UN  0.00 2.00 UN 2.00 UN	18.50     20.00 PI_\$CLB     1.00 UN     1.00       36.03     2.00 UN     2.00 UN     2.00       73.02     2.00 UN     2.00 UN     2.00       0.00     2.00 UN     2.00 UN     2.00	18.50       20.00 PI_\$CLB       1.00 UN       1.00 49.390         36.03       2.00 UN       2.00 UN       2.00 135.000         73.02       2.00 UN       2.00 UN       2.00 251.000         0.00       2.00 UN       2.00 UN       2.00 165.000

Total Weight (Lbs)

795.29

Important

This offer is based on availability and current pricing conditions that may be revised upon paraphioprofichation do l'évolution des prix de l'acier sur le marché.

Thiseoffire esubjection et conditional dite carditip protonoch du crédit.

Approuved and Accepted by:

Date :_

Sub-total

3 284.35

TVH-13 · · 426.97

Total (\$CAD)

3 711.32

MATERIAL: M6061	161	<b>3</b> ∕3,	$\infty$	C PO/BATCH NO.: po37/70/M138/15						
DATE:JUL	27	2017	7	_			<del>                                      </del>	7.07. (3515)		
MATERIAL CERT REC'D:  QUANTITY RECEIVED:  QUANTITY INSPECTED:  QUANTITY REJECTED:			THICKNESS ORDERED: 375 X 1"  THICKNESS RECEIVED: 375 X 1"  SHEET SIZE ORDERED: 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1							
DESCRIPTION	(Ch	CR neck (N)				COMMEN	ITS			
SURFACE DAMAGE	Y	TAT:	<del>;</del>							
CORRECT FINISH	N	N	<del></del>							
CORROSION	Ŷ	M					· · · · · · · · · · · · · · · · · · ·			
CORRECT GRAIN DIRECTION	(Y)	N								
CORRECT MATERIAL PER M-DRAWING	(M)	N	AStm	RY	11					
CORRECT THICKNESS	(1)	N			<u> </u>					
PHOTO REQUIRED	Ÿ	M								
CORRECT REF # TO LINK CERT	8	X	1441	31210	291	A				
CORRECT MATERIAL IDENTFICATION	8	N	6061ti	SR						
CORRECT M# ON THE MATERIAL	Y	N	6061	+6						
DOES THIS MATERIAL REQUIRE ENGINEERING SIGN OFF	Υ	B		,						
DOES THIS REQUIRE AN EXTRUSION REPORT	Υ	3				<u> </u>				
		<del></del>					<del></del>			
CUT SAMPLE PIECE	OF	MAT	TERIAL AN ORD RESU	ID PREF	ORM	A HARDNE	SS CHECK.			
			HRC T	HRB		DUR A	DUR D	LWEDSTED		
YPE OF MATERIAL	ł			- 1110	<del></del>  -	DUNA	DOND	WEBSTER		
SIZE OF TEST SAMPLE	ŀ		<del></del>					<del>                                     </del>		
ARDNESS / DUROMETER READIN	√G t		+		-+		<u> </u>	<del>                                     </del>		
		stere	located in th	a Oualita	Office		<u> </u>			
	-23		uiva iii li	oruanty	<u> Jince</u>					

QC 18 INSPECTION			ENGINEERING SIGNOFF (if required)
INSPECTED BY:_		DAS 5	SIGNED OFF BY:
DATE:	JUL 2 7 2017	9-69	DATE:

Attach this inspection sheet with the corresponding material cert and remit to be scanned and received in

# INSTRUCTIONS FOR INSPECTING BAR, TUBING, ROUND, & SHEET STOCK

- 1- VERIFY STOCK TO DART PURCHASE ORDER REQUIRMENTS
- 2- MEASURE ALL DIMENSIONS FOR EACH PURCHASED STOCK
  - a. WIDTH, THICKNESS, DIAMETER, WALL THICKNESS & LENGTH
- 3- VERIFY CONDITION OF MATERIAL i.e. DAMAGED, CORRODED, etc.
- 4- VERIFY THAT SUPPLIER HAS A NUMBER (HEAT #) ON ITS RECEIVING REPORT TO LINK TO MATERIAL CERTS
- 5- VERIFY MATERIAL CERTS ARE CORECT TO THE DART RELEASED M-DRAWING
- 6- USING PORTABLE HARDNESS TESTER VERIFY HARDNESS OF THE MATERIAL TO THE DRAWING & RECORD note Aluminum material only

### INSTRUCTIONS FOR INSPECTING SKIDTUBE & STEP EXTRUSION

- 1- VERIFY TO DART SUPPLIED DRAWING
- 2- SAMPLE INSPECT MATERIAL IN BUNDLE TO ENSURE MATERIAL CAN BE RECEIVIED INTO DART
- 3- USING PORTABLE HARDNESS TESTER VERIFY HARDNESS OF THE MATERIAL TO THE DRAWING
- 4- VERIFY THAT MATERIAL CERTS MATCH TO WHATS CALLED UP ON THE DART DRAWING

#### AFTER MATERIAL PASSES INSPECTION

- 5- HAVE DART EMPLOYEES START STOCKING MATERIAL BUT REQUEST MIN 20pcs FOR FULL INSPECTION
- 6- INSPECT ALL DIMS AS PER DRAWING REQUIRMENTS

# INSTRUCTIONS FOR INSPECTING CROSS TUBE MATERIAL

- 1- VERIFY MATERIAL CERTS MATCH THE REQUIRMENTS ON THE DART DRAWINGS.
- 2- INSPECT MIN. HALF THE BATCH OF EXTRUSION RECEIVIED INTO DART
- 3- INSPECT MATERIAL AS PER THE EXTRUSION REPORT
  - a. WALL THICKNESS USING ULTRA-SONIC IN 4 LOCATIONS
  - b. OUTSIDE DIAMETETER HIGHEST/LOWEST BOTH ENDS
  - c. INSIDE DIAMETER HIGHEST/LOWEST BOTH ENDS
  - d. STRAIGHTNESS @ CENTER OVER 12" SPAN
  - e. WALL THICKNESS USING TUBE MICROMETER HIGHEST/LOWEST BOTH ENDS
- 4- IDENTFY EACH TUBE IN SEQUENCE OF INSPECTING (TUBE 1, TUBE2.....) AND W/O# AND PO#
- 5- RECORD ALL FINDINGS ON EXTRUSION REPORT

IF ANY QUESTIONS PLEASE SEE QC CORRDINATOR BEFORE GOING FURTHER

**SPECIFICATION CONTROL DRAWING** 

PURCHASE MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR

SPECIFICATION:

B

D

С

QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160) OR ASTM B211 QR ASTM B221

DAS

PART NUMBER:

M6061T6B T.TTT | X | WW.WWW

5 9-89

THICK WIDTH WHERE "T.TTT" = THICKNESS IN INCHES "WW.WWW" = WIDTH IN INCHES

E.G. 1.0" X 12.0" BAR = M6061T6B1,000X12.000

В	REMOV ASTM E	E QQ-A-250/11 3211/B221 (ZN	OPTION, REFORMAT NOTES, ADD	CP	09.07.13			
Α	NEW IS	SUE		DS	01.06.08			
REV.			BY	DATE				
DESIG	N	DS	DART AEROSPA	ACE L	TD			
DRAW	N	9	HAWKESBURY, ONTARIO, CANADA					
CHECH	KED	AUS	DRAWING NO.		REV. B			
MFG. A	PPR.	MA	√M6061T6B	SHEET 1 OF				
APPRO	VED	MY	TITLE		SCALE			
DE API	PR.		76061-T6 BAR		NTS			
DATE	09.0	7.13	COPYRIGHT © 2001 BY DART AEROSPACE LTD  THE DOZAMENT BE HOWN THAN DOSOPROMIN, MORE SUPPLIED ON THE DOPPREAD GONOTION THAT IT IS  HOT TO BE USED FOR MAY PURPOSE OR COPIED ON COMMANNATED TO JAMY OTHER POTEON WITHOUT  WINTED PERSONATION PROJUDITE REPORTED ACT. DO.					

MATERIAL: <u>M6661</u> DATE: <u>JUL</u>	-		750X) —	600		PO / BATCH	но.: <u>роз<del>7</del>,</u>	170/M138152
MATERIAL CERT REC'D:  QUANTITY RECEIVED:  QUANTITY INSPECTED:  QUANTITY REJECTED:	<u>4</u>	es R			THIC SHEE	KNESS ORDE KNESS RECE ET SIZE ORDE ET SIZE RECE	IVED:	6)x2" 10/A
DESCRIPTION	(Ch	CR leck (N)				COMMEN	ITS	
SURFACE DAMAGE	Y	W						
CORRECT FINISH	1	N						
CORROSION	<b>)</b>	CM						
CORRECT GRAIN DIRECTION	$\otimes$	N					-	
CORRECT MATERIAL PER M-DRAWING	(	N	ASTY	<u>(B. 1</u>	71			
CORRECT THICKNESS	Ø	N						
PHOTO REQUIRED	Υ	(1)						
CORRECT REF # TO LINK CERT	$\mathcal{C}$	N	1+++	. 49	113			
CORRECT MATERIAL IDENTFICATION	X	N	6061 t	CB:				
CORRECT M# ON THE MATERIAL	Ø	N	6061.	<u>+6</u>				
DOES THIS MATERIAL REQUIRE ENGINEERING SIGN OFF	Υ	0						
DOES THIS REQUIRE AN EXTRUSION REPORT	Υ	(2)						
				,				
CUT SAMPLE PIECE			TERIAL A ORD RES				ESS CHECK.	
			HRC	HR	В	DUR A	DUR D	WEBSTER
TYPE OF MATERIAL								
SIZE OF TEST SAMPLE								
HARDNESS / DUROMETER READI	NG							
	<u>te</u>	sters	located in	the Quali	ty Offic	<u>e</u>	<del></del>	

QC 18 INSPECTION

INSPECTED BY:

DAS

SIGNED OFF BY:

DATE:

ttach this inspection sheet with the corresponding material cert and remit to be scanned and received in

\$300 m

# INSTRUCTIONS FOR INSPECTING BAR, TUBING, ROUND, & SHEET STOCK

- 1- VERIFY STOCK TO DART PURCHASE ORDER REQUIRMENTS
- 2- MEASURE ALL DIMENSIONS FOR EACH PURCHASED STOCK
  - a. WIDTH, THICKNESS, DIAMETER, WALL THICKNESS & LENGTH
- 3- VERIFY CONDITION OF MATERIAL i.e. DAMAGED, CORRODED, etc.
- 4- VERIFY THAT SUPPLIER HAS A NUMBER (HEAT #) ON ITS RECEIVING REPORT TO LINK TO MATERIAL CERTS
- 5- VERIFY MATERIAL CERTS ARE CORECT TO THE DART RELEASED M-DRAWING
- 6- USING PORTABLE HARDNESS TESTER VERIFY HARDNESS OF THE MATERIAL TO THE DRAWING & RECORD note Aluminum material only

### INSTRUCTIONS FOR INSPECTING SKIDTUBE & STEP EXTRUSION

- 1- VERIFY TO DART SUPPLIED DRAWING
- 2- SAMPLE INSPECT MATERIAL IN BUNDLE TO ENSURE MATERIAL CAN BE RECEIVIED INTO DART
- 3- USING PORTABLE HARDNESS TESTER VERIFY HARDNESS OF THE MATERIAL TO THE DRAWING
- 4- VERIFY THAT MATERIAL CERTS MATCH TO WHATS CALLED UP ON THE DART DRAWING

#### AFTER MATERIAL PASSES INSPECTION

- 5- HAVE DART EMPLOYEES START STOCKING MATERIAL BUT REQUEST MIN 20pcs FOR FULL INSPECTION
- 6- INSPECT ALL DIMS AS PER DRAWING REQUIRMENTS

### INSTRUCTIONS FOR INSPECTING CROSS TUBE MATERIAL

- 1- VERIFY MATERIAL CERTS MATCH THE REQUIRMENTS ON THE DART DRAWINGS
- 2- INSPECT MIN. HALF THE BATCH OF EXTRUSION RECEIVIED INTO DART
- 3- INSPECT MATERIAL AS PER THE EXTRUSION REPORT
  - a. WALL THICKNESS USING ULTRA-SONIC IN 4 LOCATIONS
  - b. OUTSIDE DIAMETETER HIGHEST/LOWEST BOTH ENDS
  - c. INSIDE DIAMETER HIGHEST/LOWEST BOTH ENDS
  - d. STRAIGHTNESS @ CENTER OVER 12" SPAN
  - e. WALL THICKNESS USING TUBE MICROMETER HIGHEST/LOWEST BOTH ENDS
- 4- IDENTFY EACH TUBE IN SEQUENCE OF INSPECTING (TUBE 1, TUBE2.....) AND W/O# AND PO#
- 5- RECORD ALL FINDINGS ON EXTRUSION REPORT

IF ANY QUESTIONS PLEASE SEE QC CORRDINATOR BEFORE GOING FURTHER

# **SPECIFICATION CONTROL DRAWING**

PURCHASE MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR

SPECIFICATION:

D

С

QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR QQ-A-200/8 OR AMS 38 A-200/8 (OR AMS 4160) OR ASTM B211 OR ASTM B221

Æ

DAS

PART NUMBER:

M6061T6B T.TTT | X | WW.WWW

5

THICK WIDTH 9-89

WHERE "T.TTT" = THICKNESS IN INCHES "WW.WWW" = WIDTH IN INCHES

E.G. 1.0" X 12.0" BAR = M6061T6B1.000X12.000

В	REMOV ASTM E	E QQ-A- 3211/B22	250/11 1 (ZN C	OPTION, REFORMAT NOTES, ADD	СР	09.07.13		
Α	NEW IS	SUE	DS	01.06.08				
REV.				BY	DATE			
DESIG	N	D	Ş	DART AEROSPA	CEL	TD		
DRAW	v	G.	7	HAWKESBURY, ONTARI				
CHECK	ED	A	S	DRAWING NO.		REV. B		
MFG. A	PPR.	W		M6061T6B		SHEET 1 OF 1		
APPRO	VED _	1	7	TITLE		SCALE		
DE APP	PR.	4	4-	6061-T6 BAR		NTS		
DATE	09.0	7.13	<b>7</b>	COPYRIGHT © 2001 BY DART AEROSPACE LTD THE DOCUMENT B INVAITE AND COMPORTING AND IS SUPPLES ON THE EMPLES CONDITION THAT IT IS NOT TO BE USED FOR MY PURPOSE OR COMPED OR COMMENCENTED TO AN INTERPRESSON WITHOUT WRITTEN PROSESSON FROM DAIL PROSPACE LTD.				

8

MATERIAL: MGG/1 DATE: JUL	<u>68</u> 277	1 <u>æ</u> 2017	0X),00	מ		PO / BATCH	NO.: po37//	<u>20/M13815)</u>
MATERIAL CERT REC'D:  QUANTITY RECEIVED: 20'  QUANTITY INSPECTED:  QUANTITY REJECTED:	3	es_			THIC SHE	CKNESS ORDE KNESS RECEI ET SIZE ORDE ET SIZE RECEI	VED: 1')	(2" //A
DESCRIPTION	(Ch	CR eck (N)				COMMEN	тѕ	
SURFACE DAMAGE	Y	B						
CORRECT FINISH	3	N						
CORROSION	Υ	8						
CORRECT GRAIN DIRECTION	8	N						
CORRECT MATERIAL PER M-DRAWING	3	N	ASTH	$\Sigma R$	321			
CORRECT THICKNESS	$\otimes$	N						
PHOTO REQUIRED	Y	8						
CORRECT REF # TO LINK CERT	$\otimes$	N	#	48)	97			
CORRECT MATERIAL IDENTFICATION	(1)	N	6061-	t6 B				
CORRECT M# ON THE MATERIAL	8	N	COGI	t6				
DOES THIS MATERIAL REQUIRE ENGINEERING SIGN OFF	Υ	0						
DOES THIS REQUIRE AN EXTRUSION REPORT	Υ	(N)						
			_					. "
CUT SAMPLE PIECE	OF	MA	TERIAL A	ND PI	REFOR	M A HARDNE	SS CHECK.	
	F	REC	ORD RES	ULTS	BELOV	V		
			HRC	H	RB	DUR A	DUR D	WEBSTER
TYPE OF MATERIAL								
SIZE OF TEST SAMPLE								
HARDNESS / DUROMETER READI	NG							
	<u>te</u>	sters	located in	the Qu	ality Offic	<u>:e</u>		

QC 18 INSPECTION			ENGINEERING SIGNOFF (if required)
		DAS	
INSPECTED BY:		_ 5	SIGNED OFF BY:
	1111 0 7 0047	9-89	· · · · · · · · · · · · · · · · · · ·
DATE:	JUL 2 7 2017		DATE:

Attach this inspection sheet with the corresponding material cert and remit to be scanned and received in

# INSTRUCTIONS FOR INSPECTING BAR, TUBING, ROUND, & SHEET STOCK

- 1- VERIFY STOCK TO DART PURCHASE ORDER REQUIRMENTS
- 2- MEASURE ALL DIMENSIONS FOR EACH PURCHASED STOCK
  - a. WIDTH, THICKNESS, DIAMETER, WALL THICKNESS & LENGTH
- 3- VERIFY CONDITION OF MATERIAL i.e. DAMAGED, CORRODED, etc.
- 4- VERIFY THAT SUPPLIER HAS A NUMBER (HEAT #) ON ITS RECEIVING REPORT TO LINK TO MATERIAL CERTS
- 5- VERIFY MATERIAL CERTS ARE CORECT TO THE DART RELEASED M-DRAWING
- 6- USING PORTABLE HARDNESS TESTER VERIFY HARDNESS OF THE MATERIAL TO THE DRAWING & RECORD note Aluminum material only

### INSTRUCTIONS FOR INSPECTING SKIDTUBE & STEP EXTRUSION

- 1- VERIFY TO DART SUPPLIED DRAWING
- 2- SAMPLE INSPECT MATERIAL IN BUNDLE TO ENSURE MATERIAL CAN BE RECEIVIED INTO DART
- 3- USING PORTABLE HARDNESS TESTER VERIFY HARDNESS OF THE MATERIAL TO THE DRAWING
- 4- VERIFY THAT MATERIAL CERTS MATCH TO WHATS CALLED UP ON THE DART DRAWING

#### AFTER MATERIAL PASSES INSPECTION

- 5- HAVE DART EMPLOYEES START STOCKING MATERIAL BUT REQUEST MIN 20pcs FOR FULL INSPECTION
- 6- INSPECT ALL DIMS AS PER DRAWING REQUIRMENTS

### INSTRUCTIONS FOR INSPECTING CROSS TUBE MATERIAL

- 1- VERIFY MATERIAL CERTS MATCH THE REQUIRMENTS ON THE DART DRAWINGS
- 2- INSPECT MIN. HALF THE BATCH OF EXTRUSION RECEIVIED INTO DART
- 3- INSPECT MATERIAL AS PER THE EXTRUSION REPORT
  - a. WALL THICKNESS USING ULTRA-SONIC IN 4 LOCATIONS
  - b. OUTSIDE DIAMETETER HIGHEST/LOWEST BOTH ENDS
  - c. INSIDE DIAMETER HIGHEST/LOWEST BOTH ENDS
  - d. STRAIGHTNESS @ CENTER OVER 12" SPAN
  - e. WALL THICKNESS USING TUBE MICROMETER HIGHEST/LOWEST BOTH ENDS
- 4- IDENTFY EACH TUBE IN SEQUENCE OF INSPECTING (TUBE 1, TUBE2.....) AND W/O# AND PO#
- 5- RECORD ALL FINDINGS ON EXTRUSION REPORT

IF ANY QUESTIONS PLEASE SEE QC CORRDINATOR BEFORE GOING FURTHER

# **SPECIFICATION CONTROL DRAWING**

PURCHASE MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR

SPECIFICATION:

D

QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160) OR ASTM B211 OR ASTM B221

PART NUMBER:

ß

DAS M6061T6B T.TTT | X | WW.WWW

WHERE "T.TTT" = THICKNESS IN INCHES
"WW.WWW" = WIDTH IN INCHES

E.G. 1.0" X 12.0" BAR = M6061T6B1.000X12.000

В	REMOV ASTM E	E QQ-A-250/11 3211/B221 (ZN	OPTION, REFORMAT NOTES, ADD D7-1)	СР	09.07.13			
A	NEW IS	SUE		DS	01.06.08			
REV.			BY	DATE				
DESIG	N	DS	DART AEROSP	ACE L	TD			
DRAW	N	9	HAWKESBURY, ONTAR	DA				
CHECK	(ED	ZUS.	DRAWING NO.		REV. B			
MFG. A	PPR.	$M_{\sim}$	M6061T6B		SHEET 1 OF 1			
APPRO	OVED	MY	TITLE		SCALE			
DE API	PR.		6061-T6 BAR	NTS				
DATE	09.0	7.13	THE DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLE MOT TO BE USED FOR MAY PURPOSE OR COPIED OR COMMUNIC	COPYRIGHT © 2001 BY DART AEROSPACE LTD THE DOCUMENT IS WANTE AND COMPOSITION, AND IS SUFFICION FOR COMPOSITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE ON COMPOSITION THAT IT IS WITTEN PERMISSION FROM DART APROVACE LTD.				

В

MATERIAL: MCG614	CB.	1,50	~ X150	$\infty$	PO/BATCH NO.: <u>0037/70/M138/5</u>						
DATE: JUL 2	<del>-7-7</del> 1	<del>117</del>		_					•		
MATERIAL CERT REC'D:  QUANTITY RECEIVED:  QUANTITY INSPECTED:  QUANTITY REJECTED:	\ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \	Q		- - -	T S	HIC	CKNESS OF CKNESS RE ET SIZE OF ET SIZE RE	ECEI RDEI	VED: RED:	1 <u>.5</u> 1.5	5"X15" 1X15"
DESCRIPTION	(Ch	CR leck (N)			<del></del>		СОММ	1EN7	гѕ		
SURFACE DAMAGE	Y				·						
CORRECT FINISH	K)		<del></del>								
CORROSION	Y	Ø		_							
CORRECT GRAIN DIRECTION	185						<del></del>				
CORRECT MATERIAL PER M-DRAWING	8	N	Astro	<u> </u>	20	) l					
CORRECT THICKNESS	8	N	100,00	-	000		- 4				
PHOTO REQUIRED	Y	0		_				-			
CORRECT REF # TO LINK CERT	B	N	111 #	2/2	805	<del>F</del>					
CORRECT MATERIAL IDENTFICATION		N	60617	F/.	R						
CORRECT M# ON THE MATERIAL	M/	N	60611	6	<del> </del>						
DOES THIS MATERIAL REQUIRE ENGINEERING SIGN OFF	Υ	AT					<u>.</u>		u		
DOES THIS REQUIRE AN		Q									
EXTRUSION REPORT	Υ	0									
					_						:
CUT SAMPLE PIECE			TERIAL A					ONE	SS CHEC	K.	
			HRC		HRB	Ť	DUR A	1	DUR E	5 1	WEBSTER
TYPE OF MATERIAL						一				$\dashv$	
SIZE OF TEST SAMPLE						T					
HARDNESS / DUROMETER READI	٧G										
	<u>te</u>	<u>sters</u>	located in	the	Quality (	Offic	<u>e</u>				
QC 18 INSPECTION							ENGIN	EER	RING SIGN	IOF	F (if required)

Attach this inspection sheet with the corresponding material cert and remit to be scanned and received in

SIGNED OFF BY:

DATE:

DAS

9-89

JUL 27 2017

INSPECTED BY: _

DATE:

# INSTRUCTIONS FOR INSPECTING BAR, TUBING, ROUND, & SHEET STOCK

- 1- VERIFY STOCK TO DART PURCHASE ORDER REQUIRMENTS
- 2- MEASURE ALL DIMENSIONS FOR EACH PURCHASED STOCK
  - a. WIDTH, THICKNESS, DIAMETER, WALL THICKNESS & LENGTH
- 3- VERIFY CONDITION OF MATERIAL i.e. DAMAGED, CORRODED, etc.
- 4- VERIFY THAT SUPPLIER HAS A NUMBER (HEAT #) ON ITS RECEIVING REPORT TO LINK TO MATERIAL CERTS
- 5- VERIFY MATERIAL CERTS ARE CORECT TO THE DART RELEASED M-DRAWING
- 6- USING PORTABLE HARDNESS TESTER VERIFY HARDNESS OF THE MATERIAL TO THE DRAWING & RECORD note Aluminum material only

# INSTRUCTIONS FOR INSPECTING SKIDTUBE & STEP EXTRUSION

- 1- VERIFY TO DART SUPPLIED DRAWING
- 2- SAMPLE INSPECT MATERIAL IN BUNDLE TO ENSURE MATERIAL CAN BE RECEIVIED INTO DART
- 3- USING PORTABLE HARDNESS TESTER VERIFY HARDNESS OF THE MATERIAL TO THE DRAWING
- 4- VERIFY THAT MATERIAL CERTS MATCH TO WHATS CALLED UP ON THE DART DRAWING

#### AFTER MATERIAL PASSES INSPECTION

- 5- HAVE DART EMPLOYEES START STOCKING MATERIAL BUT REQUEST MIN 20pcs FOR FULL INSPECTION
- 6- INSPECT ALL DIMS AS PER DRAWING REQUIRMENTS

### INSTRUCTIONS FOR INSPECTING CROSS TUBE MATERIAL

- 1- VERIFY MATERIAL CERTS MATCH THE REQUIRMENTS ON THE DART DRAWINGS
- 2- INSPECT MIN. HALF THE BATCH OF EXTRUSION RECEIVIED INTO DART
- 3- INSPECT MATERIAL AS PER THE EXTRUSION REPORT
  - a. WALL THICKNESS USING ULTRA-SONIC IN 4 LOCATIONS
  - b. OUTSIDE DIAMETETER HIGHEST/LOWEST BOTH ENDS
  - c. INSIDE DIAMETER HIGHEST/LOWEST BOTH ENDS
  - d. STRAIGHTNESS @ CENTER OVER 12" SPAN
  - e. WALL THICKNESS USING TUBE MICROMETER HIGHEST/LOWEST BOTH ENDS
- 4- IDENTFY EACH TUBE IN SEQUENCE OF INSPECTING (TUBE 1, TUBE2.....) AND W/O# AND PO#
- 5- RECORD ALL FINDINGS ON EXTRUSION REPORT

IF ANY QUESTIONS PLEASE SEE QC CORRDINATOR BEFORE GOING FURTHER

**SPECIFICATION CONTROL DRAWING** 

PURCHASE MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR

QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR QQ-A-200/8 OR AMS 43 A-200/8 (OR AMS 4160) OR ASTM B211 OR ASTM B221

ß

D

PART NUMBER:

M6061T6B T.TTT | X | WW.WWW

DAS 5

THICK WIDTH 9-89

WHERE "T.TTT" = THICKNESS IN INCHES
"WW.WWW" = WIDTH IN INCHES

E.G. 1.0" X 12.0" BAR = M6061T6B1.000X12.000

В

В	REMOV ASTM E	/E QQ-A-250/11 3211/B221 (ZN 1	СР	09.07.13				
A	NEW IS	SUE	DS	01.06.08				
REV.			BY	DATE				
DESIG	N	DS	DART AEROSPA	ACEL	TD			
DRAW	N	9	HAWKESBURY, ONTAR	RIO, CANADA				
CHECH	ŒD	AUS	DRAWING NO.		REV. B			
MFG. A	PPR.	$M_{\sim}$	M6061T6B	SHEET 1 OF 1				
APPRO	VED	MY	TITLE		SCALE			
DE API	PR.		76061-T6 BAR		NTS			
DATE	09.0	7.13	COPYRIGHT © 2001 BY DART AEROSPACE LTD  THIS DOCUMENT IS PRIVATE AND COMPOSITION AND IS SUPPLETO ON THE EXPRESS CONCINON THAT IT IS  HIGH TO BE USED FOR MY PURPOSE OR COMPANIENCE TO TO ANY OTHER REPOSEM WITHOUT  WHITTEN PERMISSION PROMI DART APPOSPACE LTD.					

MATERIAL: MGGI	+6B	1,50	30X)50	po/batch no.: <u>pc37/20/m13816</u> 3						
DATE: JUL 2	7 7	<del>017</del>		_			•	•		
MATERIAL CERT REC'D:  QUANTITY RECEIVED: 12'  QUANTITY INSPECTED:  QUANTITY REJECTED:	4	017 <u>25</u>		- - -	THICKNESS ORDERED:  THICKNESS RECEIVED:  SHEET SIZE ORDERED:  SHEET SIZE RECEIVED:					
DESCRIPTION	(Ch	CR eck (N)				COMMEN	rs			
SURFACE DAMAGE	Y	(1)								
CORRECT FINISH	$\geq$	N								
CORROSION	Υ	R								
CORRECT GRAIN DIRECTION	3	M								
CORRECT MATERIAL PER M-DRAWING	8	N	AStr	$\mathcal{R}$	2]_					
CORRECT THICKNESS	$\odot$	N	,							
PHOTO REQUIRED	Υ	1								
CORRECT REF # TO LINK CERT	8	N	11/#	SXL	170	940				
CORRECT MATERIAL IDENTFICATION	8	N	6061	16B		- •				
CORRECT M# ON THE MATERIAL	8	N	60C1+	6						
DOES THIS MATERIAL REQUIRE ENGINEERING SIGN OFF	Υ	RB								
DOES THIS REQUIRE AN EXTRUSION REPORT	Υ									
CUT SAMPLE PIECE			TERIAL A				SS CHECK.			
			HRC	HRI		DUR A	DUR D	WEBSTER		
TYPE OF MATERIAL				-				`		
SIZE OF TEST SAMPLE	í							<del>                                     </del>		
HARDNESS / DUROMETER READ!	NG									
		sters	located in	the Qualit	v Offic	<u> </u>				
	_					_				

Attach this inspection sheet with the corresponding material cert and remit to be scanned and received in

ENGINEERING SIGNOFF (if required)

SIGNED OFF BY: __

DATE:

1111 7 7 2017

QC 18 INSPECTION

INSPECTED BY:

DATE:

# INSTRUCTIONS FOR INSPECTING BAR, TUBING, ROUND, & SHEET STOCK

- 1- VERIFY STOCK TO DART PURCHASE ORDER REQUIRMENTS
- 2- MEASURE ALL DIMENSIONS FOR EACH PURCHASED STOCK
  - a. WIDTH, THICKNESS, DIAMETER, WALL THICKNESS & LENGTH
- 3- VERIFY CONDITION OF MATERIAL i.e. DAMAGED, CORRODED, etc.
- 4- VERIFY THAT SUPPLIER HAS A NUMBER (HEAT #) ON ITS RECEIVING REPORT TO LINK TO MATERIAL CERTS
- 5- VERIFY MATERIAL CERTS ARE CORECT TO THE DART RELEASED M-DRAWING
- 6- USING PORTABLE HARDNESS TESTER VERIFY HARDNESS OF THE MATERIAL TO THE DRAWING & RECORD note Aluminum material only

### INSTRUCTIONS FOR INSPECTING SKIDTUBE & STEP EXTRUSION

- 1- VERIFY TO DART SUPPLIED DRAWING
- 2- SAMPLE INSPECT MATERIAL IN BUNDLE TO ENSURE MATERIAL CAN BE RECEIVIED INTO DART
- 3- USING PORTABLE HARDNESS TESTER VERIFY HARDNESS OF THE MATERIAL TO THE DRAWING
- 4- VERIFY THAT MATERIAL CERTS MATCH TO WHATS CALLED UP ON THE DART DRAWING

#### AFTER MATERIAL PASSES INSPECTION

- 5- HAVE DART EMPLOYEES START STOCKING MATERIAL BUT REQUEST MIN 20pcs FOR FULL INSPECTION
- 6- INSPECT ALL DIMS AS PER DRAWING REQUIRMENTS

### INSTRUCTIONS FOR INSPECTING CROSS TUBE MATERIAL

- 1- VERIFY MATERIAL CERTS MATCH THE REQUIRMENTS ON THE DART DRAWINGS
- 2- INSPECT MIN. HALF THE BATCH OF EXTRUSION RECEIVIED INTO DART
- 3- INSPECT MATERIAL AS PER THE EXTRUSION REPORT
  - a. WALL THICKNESS USING ULTRA-SONIC IN 4 LOCATIONS
  - b. OUTSIDE DIAMETETER HIGHEST/LOWEST BOTH ENDS
  - c. INSIDE DIAMETER HIGHEST/LOWEST BOTH ENDS
  - d. STRAIGHTNESS @ CENTER OVER 12" SPAN
  - e. WALL THICKNESS USING TUBE MICROMETER HIGHEST/LOWEST BOTH ENDS
- 4- IDENTFY EACH TUBE IN SEQUENCE OF INSPECTING (TUBE 1, TUBE2.....) AND W/O# AND PO#
- 5- RECORD ALL FINDINGS ON EXTRUSION REPORT

IF ANY QUESTIONS PLEASE SEE QC CORRDINATOR BEFORE GOING FURTHER

**SPECIFICATION CONTROL DRAWING** D PURCHASE MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR QQ-A-200/8 OR AMS-<del>QQ A-2</del>00/8 (OR AMS 4160) OR ASTM B211 OR ASTM B221 DAS SPECIFICATION: A DAS PART NUMBER: M6061T6B T.TTT | X | WW.WWW 9-69 THICK WIDTH WHERE "T.TTT" = THICKNESS IN INCHES "WW.WWW" = WIDTH IN INCHES E.G. 1.0" X 12.0" BAR = M6061T6B1.000X12.000 REMOVE QQ-A-250/11 OPTION, REFORMAT NOTES, ADD ASTM B211/B221 (ZN D7-1) 09.07.13 NEW ISSUE A DS 01.06.08 REV. DESCRIPTION BY DATE DESIGN DS DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA CHECKED DRAWING NO. REV. B M6061T6B MFG. APPR. SHEET 1 OF 1 APPROVED TITLE SCALE 6061-T6 BAR DE APPR. NTS COPYRIGHT © 2001 BY BART AEROSPACE LTD

THIS DOCUMENT OF PRIVITY AND COMPEDITING, MID IS SEPPLED ON THE SOMESS CONDITION THAT IT IS

BOT TO BE USED FOR ANY PURPOSE OR COMPEDITION TO THAT FOR THE ORIGINATION.

THE STATE OF THE PRIVING THE ORIGINATION OF THE ORIGINATION OF THE ORIGINATION. DATE 09.07.13

MATERIAL CERT REC'D:  QUANTITY RECEIVED: 6459ft  QUANTITY INSPECTED: 6459ft  QUANTITY REJECTED:  NCR (Check Y/N)  SURFACE DAMAGE  CORRECT FINISH  CORRECTOR  THICKNESS ORDERED THICKNESS ORDERED THICKNESS ORDERED THICKNESS ORDERED THICKNESS ORDERED THICKNESS ORDERED THICKNESS ORDERED THICKNESS ORDERED THICKNESS ORDERED THICKNESS ORDERED THICKNESS ORDERED THICKNESS ORDERED THICKNESS ORDERED THICKNESS ORDERED THICKNESS ORDERED THICKNESS ORDERED THICKNESS ORDERED THICKNESS ORDERED THICKNESS ORDERED THICKNESS ORDERED THICKNESS ORDERED THICKNESS ORDERED THICKNESS ORDERED THICKNESS ORDERED THICKNESS ORDERED THICKNESS ORDERED THICKNESS ORDERED THICKNESS ORDERED THICKNESS ORDERED THICKNESS ORDERED THICKNESS ORDERED THICKNESS ORDERED THICKNESS ORDERED THICKNESS ORDERED THICKNESS ORDERED THICKNESS ORDERED THICKNESS ORDERED THICKNESS ORDERED THICKNESS ORDERED THICKNESS ORDERED THICKNESS ORDERED THICKNESS ORDERED THICKNESS ORDERED THICKNESS ORDERED THICKNESS ORDERED THICKNESS ORDERED THICKNESS ORDERED THICKNESS ORDERED THICKNESS ORDERED THICKNESS ORDERED THICKNESS ORDERED THICKNESS ORDERED THICKNESS ORDERED THICKNESS ORDERED THICKNESS ORDERED THICKNESS ORDERED THICKNESS ORDERED THICKNESS ORDERED THICKNESS ORDERED THICKNESS ORDERED THICKNESS ORDERED THICKNESS ORDERED THICKNESS ORDERED THICKNESS ORDERED THICKNESS ORDERED THICKNESS ORDERED THICKNESS ORDERED THICKNESS ORDERED THICKNESS ORDERED THICKNESS ORDERED THICKNESS ORDERED THICKNESS ORDERED THICKNESS ORDERED THICKNESS ORDERED THICKNESS ORDERED THICKNESS ORDERED THICKNESS ORDERED THICKNESS ORDERED THICKNESS ORDERED THICKNESS ORDERED THICKNESS ORDERED THICKNESS ORDERED THICKNESS ORDERED THICKNESS ORDERED THICKNESS ORDERED THICKNESS ORDERED THICKNESS ORDERED THICKNESS ORDERED THICKNESS ORDERED THICKNESS ORDERED THICKNESS ORDERED THICKNESS ORDERED THICKNESS ORDERED THICKNESS ORDERED THICKNESS ORDERED THICKNESS ORDERED THICKNESS ORDERED THICKNESS ORDERED THICKNESS ORDERED THICKNESS ORDERED THICKNESS ORDERED THICKNESS ORDERED THICKNESS ORDERED THICKNESS ORDERED THICKNESS ORDERED	):3	
DESCRIPTION         (Check Y/N)         COMMENTS           SURFACE DAMAGE         Y         05           CORRECT FINISH         Y         N	: <u>418</u>	
CORRECT FINISH W N	<u>.</u> .	
CODDOCION		
CORROSION Y (N'		
CORRECT GRAIN DIRECTION   Ø N		
CORRECT MATERIAL PER M-DRAWING & N 45tm B209		
CORRECT THICKNESS Ø N		
PHOTO REQUIRED Y 🐠		
CORRECT REF # TO LINK CERT Ø N H+ # 487/15		
CORRECT MATERIAL IDENTFICATION (8) N 6061465		
CORRECT M# ON THE MATERIAL ON N GOCI +G		
DOES THIS MATERIAL REQUIRE Y		
DOES THIS REQUIRE AN EXTRUSION REPORT Y		
CUT SAMPLE PIECE OF MATERIAL AND PREFORM A HARDNESS RECORD RESULTS BELOW	CHECK.	
	DUR D	WEBSTER
TYPE OF MATERIAL HRB DUR A	ט אטט	WEBSIER
SIZE OF TEST SAMPLE		
HARDNESS / DUROMETER READING		
testers located in the Quality Office	-	

ENGINEERING SIGNOFF (if required)

Attach this inspection sheet with the corresponding material cert and remit to be scanned and received in

QC 18 INSPECTION

ALAN V

# INSTRUCTIONS FOR INSPECTING BAR, TUBING, ROUND, & SHEET STOCK

- 1- VERIFY STOCK TO DART PURCHASE ORDER REQUIRMENTS
- 2- MEASURE ALL DIMENSIONS FOR EACH PURCHASED STOCK
  - a. WIDTH, THICKNESS, DIAMETER, WALL THICKNESS & LENGTH
- 3- VERIFY CONDITION OF MATERIAL i.e. DAMAGED, CORRODED, etc.
- 4- VERIFY THAT SUPPLIER HAS A NUMBER (HEAT #) ON ITS RECEIVING REPORT TO LINK TO MATERIAL CERTS
- 5- VERIFY MATERIAL CERTS ARE CORECT TO THE DART RELEASED M-DRAWING
- 6- USING PORTABLE HARDNESS TESTER VERIFY HARDNESS OF THE MATERIAL TO THE DRAWING & RECORD note Aluminum material only

#### INSTRUCTIONS FOR INSPECTING SKIDTUBE & STEP EXTRUSION

- 1- VERIFY TO DART SUPPLIED DRAWING
- 2- SAMPLE INSPECT MATERIAL IN BUNDLE TO ENSURE MATERIAL CAN BE RECEIVIED INTO DART
- 3- USING PORTABLE HARDNESS TESTER VERIFY HARDNESS OF THE MATERIAL TO THE DRAWING
- 4- VERIFY THAT MATERIAL CERTS MATCH TO WHATS CALLED UP ON THE DART DRAWING

#### AFTER MATERIAL PASSES INSPECTION

- 5- HAVE DART EMPLOYEES START STOCKING MATERIAL BUT REQUEST MIN 20pcs FOR FULL INSPECTION
- 6- INSPECT ALL DIMS AS PER DRAWING REQUIRMENTS

### INSTRUCTIONS FOR INSPECTING CROSS TUBE MATERIAL

- 1- VERIFY MATERIAL CERTS MATCH THE REQUIRMENTS ON THE DART DRAWINGS
- 2- INSPECT MIN. HALF THE BATCH OF EXTRUSION RECEIVIED INTO DART
- 3- INSPECT MATERIAL AS PER THE EXTRUSION REPORT
  - a. WALL THICKNESS USING ULTRA-SONIC IN 4 LOCATIONS
  - b. OUTSIDE DIAMETETER HIGHEST/LOWEST BOTH ENDS
  - c. INSIDE DIAMETER HIGHEST/LOWEST BOTH ENDS
  - d. STRAIGHTNESS @ CENTER OVER 12" SPAN
  - e. WALL THICKNESS USING TUBE MICROMETER HIGHEST/LOWEST BOTH ENDS
- 4- IDENTFY EACH TUBE IN SEQUENCE OF INSPECTING (TUBE 1, TUBE2.....) AND W/O# AND PO#
- 5- RECORD ALL FINDINGS ON EXTRUSION REPORT

IF ANY QUESTIONS PLEASE SEE QC CORRDINATOR BEFORE GOING FURTHER

**SPECIFICATION CONTROL DRAWING** D PURCHASE MATERIAL: 6061-T6/T62 ALUMINUM SHEET QQ-A-250/11 OR AMS-QQ-A-250/11 OR AMS-4025-OR AMS-40AS OR ASTM B209 SPECIFICATION: ß OR ASTM B209 M6061T6S XXX PART NUMBER: 9-89 WHERE "XXX" = SHEET THICKNESS (IN INCHES) EG. 0.063" THICK SHEET = M6061T6S.063 PREFERRED SIZE: ,XXX BY 4FT BY 8FT С REFORMAT DWG, ADD B209 SPEC (ZN D8-1), REF PAR 08-020A 09.07.13 A NEW ISSUE DS 01.06.08 REV. DESCRIPTION BY DATE DESIGN DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA CHECKED DRAWING NO. REV. B M6061T6S MFG. APPR. SHEET 1 OF 1 APPROVED SCALE 6061-T6 SHEET SPEC DE APPR. NTS COPYRIGHT © 2001 BY DART AEROSPACE LTD
THE DOCUMENT IN PRINCIP AND COMPOSITING, AND IS SUPPLED ON THE EUPRESS CONDITING
NOT TO BE USED FOR ANY PURPOSE OR COPED OR COMMANICATED TO ANY OTHER PERSON. DATE 09.07.13

MATERIAL: <u>MCOCIHCS-080</u> DATE: <u>JUL 2 7 2017</u>					ро/ватсн no.: <del>роЗ7/70/М/38/5</del> )				
MATERIAL CERT REC'D: YES  QUANTITY RECEIVED: GYS9F+  QUANTITY INSPECTED: GYS9F+  QUANTITY REJECTED:				THICKNESS ORDERED:  THICKNESS RECEIVED:  SHEET SIZE ORDERED:  WYS  SHEET SIZE RECEIVED:					
DESCRIPTION	NCR (Check Y/N)			_	-	COMMEN	TS		
SURFACE DAMAGE	Y	400							
CORRECT FINISH	8	N							
CORROSION	X	M							
CORRECT GRAIN DIRECTION	Ø	N							
CORRECT MATERIAL PER M-DRAWING	Ø	N	Astr	ゝ	Boa	i	-		
CORRECT THICKNESS	(8)	N		•		•			
PHOTO REQUIRED	Υ	<b>®</b>					-		
CORRECT REF # TO LINK CERT	8	N	H+#	-35	897	3			
CORRECT MATERIAL IDENTFICATION		Z	60611	<del>6</del> S					
CORRECT M# ON THE MATERIAL	$\otimes$	Z	60611	8					
DOES THIS MATERIAL REQUIRE ENGINEERING SIGN OFF	Y	8							
DOES THIS REQUIRE AN EXTRUSION REPORT	Υ	3						·	
CUT SAMPLE PIECE			TERIAL A				SS CHECK		
			HRC		HRB	DUR A	DUR D	WEBSTER	
TYPE OF MATERIAL						1	1		
SIZE OF TEST SAMPLE							1		
HARDNESS / DUROMETER READI	NG			_		1	1		
		sters	located in	the O	uality Offi	ice	<del></del>		
						<del></del>			

QC 18 INSPECTION

DAS
INSPECTED BY:

DATE: JUL 27 2017

ENGINEERING SIGNOFF (if required)

SIGNED OFF BY:

DATE:

DATE:

Attach this inspection sheet with the corresponding material cert and remit to be scanned and received in

# INSTRUCTIONS FOR INSPECTING BAR, TUBING, ROUND, & SHEET STOCK

- 1- VERIFY STOCK TO DART PURCHASE ORDER REQUIRMENTS
- 2- MEASURE ALL DIMENSIONS FOR EACH PURCHASED STOCK
  - WIDTH, THICKNESS, DIAMETER, WALL THICKNESS & LENGTH
- 3- VERIFY CONDITION OF MATERIAL i.e. DAMAGED, CORRODED, etc.
- 4- VERIFY THAT SUPPLIER HAS A NUMBER (HEAT #) ON ITS RECEIVING REPORT TO LINK TO MATERIAL CERTS
- 5- VERIFY MATERIAL CERTS ARE CORECT TO THE DART RELEASED M-DRAWING
- 6- USING PORTABLE HARDNESS TESTER VERIFY HARDNESS OF THE MATERIAL TO THE DRAWING & RECORD note Aluminum material only

### INSTRUCTIONS FOR INSPECTING SKIDTUBE & STEP EXTRUSION

- 1- VERIEY TO DART SUPPLIED DRAWING
- 2- SAMPLE INSPECT MATERIAL IN BUNDLE TO ENSURE MATERIAL CAN BE RECEIVIED INTO DART
- 3- USING PORTABLE HARDNESS TESTER VERIFY HARDNESS OF THE MATERIAL TO THE DRAWING
- 4- VERIFY THAT MATERIAL CERTS MATCH TO WHATS CALLED UP ON THE DART DRAWING

#### AFTER MATERIAL PASSES INSPECTION

- 5- HAVE DART EMPLOYEES START STOCKING MATERIAL BUT REQUEST MIN 20pcs FOR FULL INSPECTION
- 6- INSPECT ALL DIMS AS PER DRAWING REQUIRMENTS

### INSTRUCTIONS FOR INSPECTING CROSS TUBE MATERIAL

- 1- VERIFY MATERIAL CERTS MATCH THE REQUIRMENTS ON THE DART DRAWINGS
- 2- INSPECT MIN. HALF THE BATCH OF EXTRUSION RECEIVIED INTO DART
- 3- INSPECT MATERIAL AS PER THE EXTRUSION REPORT
  - a. WALL THICKNESS USING ULTRA-SONIC IN 4 LOCATIONS
  - b. OUTSIDE DIAMETETER HIGHEST/LOWEST BOTH ENDS
  - c. INSIDE DIAMETER HIGHEST/LOWEST BOTH ENDS
  - d. STRAIGHTNESS @ CENTER OVER 12" SPAN
  - e. WALL THICKNESS USING TUBE MICROMETER HIGHEST/LOWEST BOTH ENDS
- 4- IDENTFY EACH TUBE IN SEQUENCE OF INSPECTING (TUBE 1, TUBE2.....) AND W/O# AND PO#
- 5- RECORD ALL FINDINGS ON EXTRUSION REPORT

IF ANY QUESTIONS PLEASE SEE QC CORRDINATOR BEFORE GOING FURTHER

**SPECIFICATION CONTROL DRAWING** 

PURCHASE MATERIAL: 6061-T6/T62 ALUMINUM SHEET

SPECIFICATION:

QQ-A-250/11 OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 1025 OR ASTM B209

ß

PART NUMBER:

9-89

WHERE ".XXX" = SHEET THICKNESS (IN INCHES)

EG. 0.063" THICK SHEET = M6061T6S.063

PREFERRED SIZE:

.XXX BY 4FT BY 8FT

REFORI	MAT DWG, A R 08-020A	СР	09.07.13		
NEW IS	SUE	DS	01.06.08		
		BY	DATE		
٧	4	DART AERO	SPACE L	TD	
V	ap				
ED	17	DRAWING NO.		REV. B	
PPR.	1/11	ДМ6061Т6S		SHEET 1 OF 1	
VED	1111	TITLE		SCALE	
PR.		6061-T6 SHEET S	PEC	NTS	
DATE 09.07.13 COPYRIGHT & 2001 BY DART A EROSPACE LTD has sociated a report we correspond, to go a service or the Europea control with it is not to set used from which report on copies on consumeration to not relieve instruction with the complete instruction of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of the control of					
	NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NEW IS NE	NEW ISSUE  N N N PPR.  NVED PR.	DESCRIPTION  DART AERO HAWKESBURY, OF DED DRAWING NO. M6061T6S  TITLE 6061-T6 SHEET S COPYRIGHT & 2001 BY THE SOCIABLE HE HAWTH MG COPEDIN	NEW ISSUE  DESCRIPTION  DART AEROSPACE L  HAWKESBURY, ONTARIO, CANA  DARYWING NO.  PPR.  M6061T6S  NED  DRAWING NO.  M6061T6S  MED  COPYRIGHT 6 2801 BY DART AEROSPACE  COPYRIGHT 6 2801 BY DART AEROSPACE  DRAWING NO.  COPYRIGHT 6 2801 BY DART AEROSPACE  DRAWING NO.  COPYRIGHT 6 2801 BY DART AEROSPACE  DRAWING NO.  COPYRIGHT 6 2801 BY DART AEROSPACE  DRAWING NO.  COPYRIGHT 6 2801 BY DART AEROSPACE  DRAWING NO.  COPYRIGHT 6 2801 BY DART AEROSPACE  DRAWING NO.  COPYRIGHT 6 2801 BY DART AEROSPACE  DRAWING NO.  COPYRIGHT 6 2801 BY DART AEROSPACE  DRAWING NO.  COPYRIGHT 6 2801 BY DART AEROSPACE  DRAWING NO.  COPYRIGHT 6 2801 BY DART AEROSPACE  DRAWING NO.  COPYRIGHT 6 2801 BY DART AEROSPACE  DRAWING NO.  COPYRIGHT 6 2801 BY DART AEROSPACE  DRAWING NO.  COPYRIGHT 6 2801 BY DART AEROSPACE  DRAWING NO.  COPYRIGHT 6 2801 BY DART AEROSPACE  DRAWING NO.  COPYRIGHT 6 2801 BY DART AEROSPACE  DRAWING NO.  COPYRIGHT 6 2801 BY DART AEROSPACE  DRAWING NO.  COPYRIGHT 6 2801 BY DART AEROSPACE  DRAWING NO.  COPYRIGHT 6 2801 BY DART AEROSPACE  DRAWING NO.  COPYRIGHT 6 2801 BY DART AEROSPACE  DRAWING NO.  COPYRIGHT 6 2801 BY DART AEROSPACE  DRAWING NO.  COPYRIGHT 6 2801 BY DART AEROSPACE  DRAWING NO.  COPYRIGHT 6 2801 BY DART AEROSPACE  DRAWING NO.  COPYRIGHT 6 2801 BY DART AEROSPACE  DRAWING NO.  COPYRIGHT 6 2801 BY DART AEROSPACE  DRAWING NO.  COPYRIGHT 6 2801 BY DART AEROSPACE  DRAWING NO.  COPYRIGHT 6 2801 BY DART AEROSPACE  DRAWING NO.  COPYRIGHT 6 2801 BY DART AEROSPACE  DRAWING NO.  COPYRIGHT 6 2801 BY DART AEROSPACE  DRAWING NO.  COPYRIGHT 6 2801 BY DART AEROSPACE  DRAWING NO.  COPYRIGHT 6 2801 BY DART AEROSPACE  DRAWING NO.  COPYRIGHT 6 2801 BY DART AEROSPACE  DRAWING NO.  COPYRIGHT 6 2801 BY DART AEROSPACE  DRAWING NO.  COPYRIGHT 6 2801 BY DART AEROSPACE  DRAWING NO.  COPYRIGHT 6 2801 BY DART AEROSPACE  DRAWING NO.  COPYRIGHT 6 2801 BY DART AEROSPACE  DRAWING NO.  COPYRIGHT 6 2801 BY DART AEROSPACE  DRAWING NO.  COPYRIGHT 6 2801 BY DART AEROSPACE  DRAWING NO.  COPYRIGHT 6 2801 BY DART AEROSPACE  DRAWING NO.  COPYRIGHT 6 2801	